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E21B 43/10

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US 4420866 A
US 3191677 A

(58) Field of Search:
INT CL[7] E21B
Other: EPODOC, JAPIO, WPI, TXTE (FULLTEXT)

(54) Abstract Title: **Mono diameter wellbore casing**

(57) A method for forming a mono diameter wellbore casing within a borehole that includes a preexisting wellbore casing, comprising: supporting the expandable tubular member 12, an hydraulic actuator 20 and an adjustable expansion device 24 within the borehole 30, increasing the size of the adjustable expansion device; displacing the adjustable expansion device upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member; and displacing the adjustable expansion device upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member and a portion of the preexisting wellbore casing that overlaps with an end of the remaining portion of the expandable tubular member.

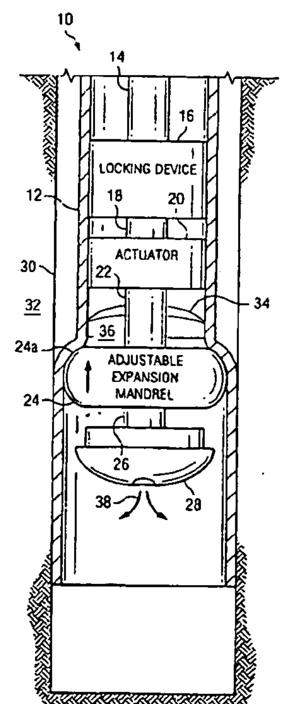

Fig. 6a

GB 2 414 749

GB 2414749 A continuation

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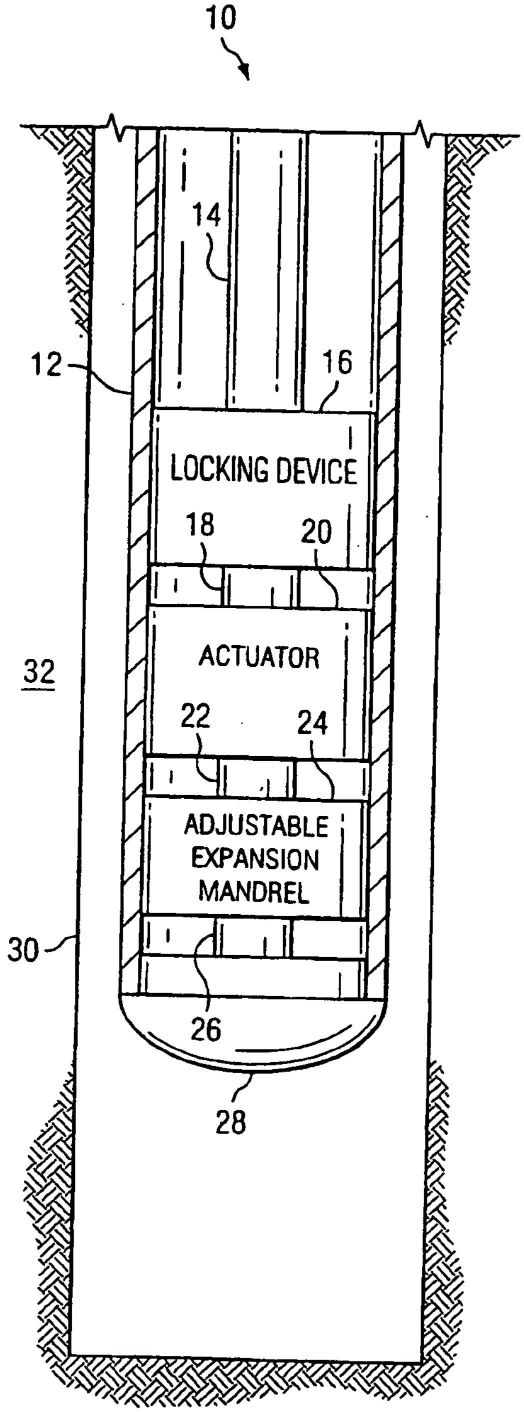
BRISTOL, BS1 6HU, United Kingdom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ACTUATOR
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Fig. 1

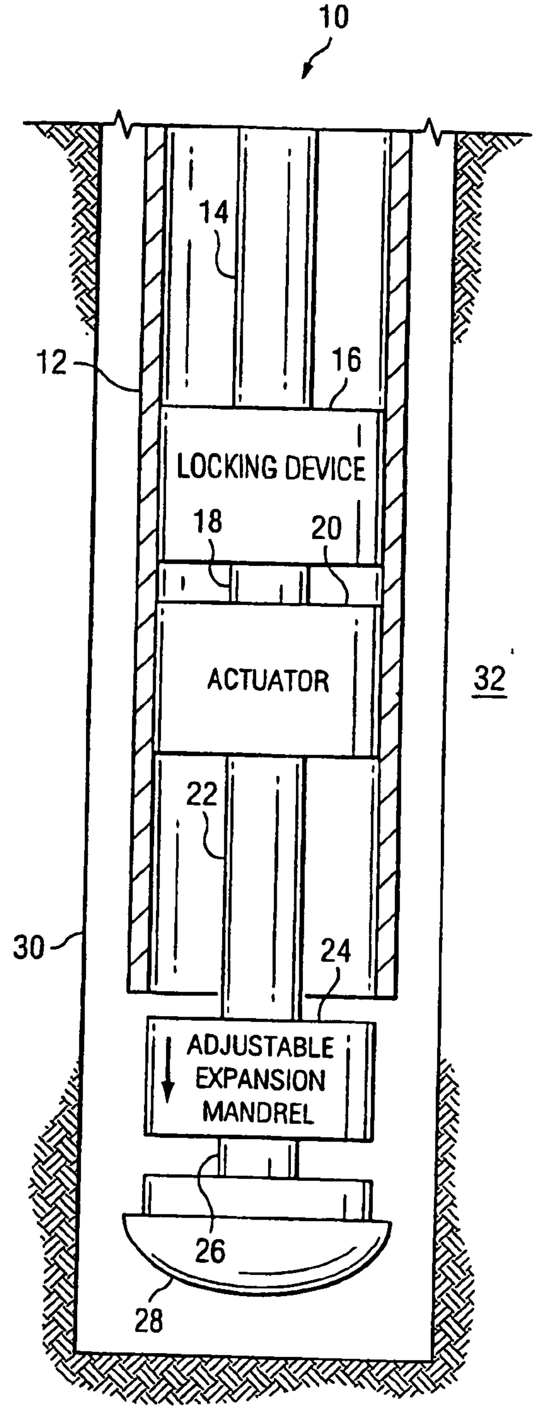
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Fig. 2

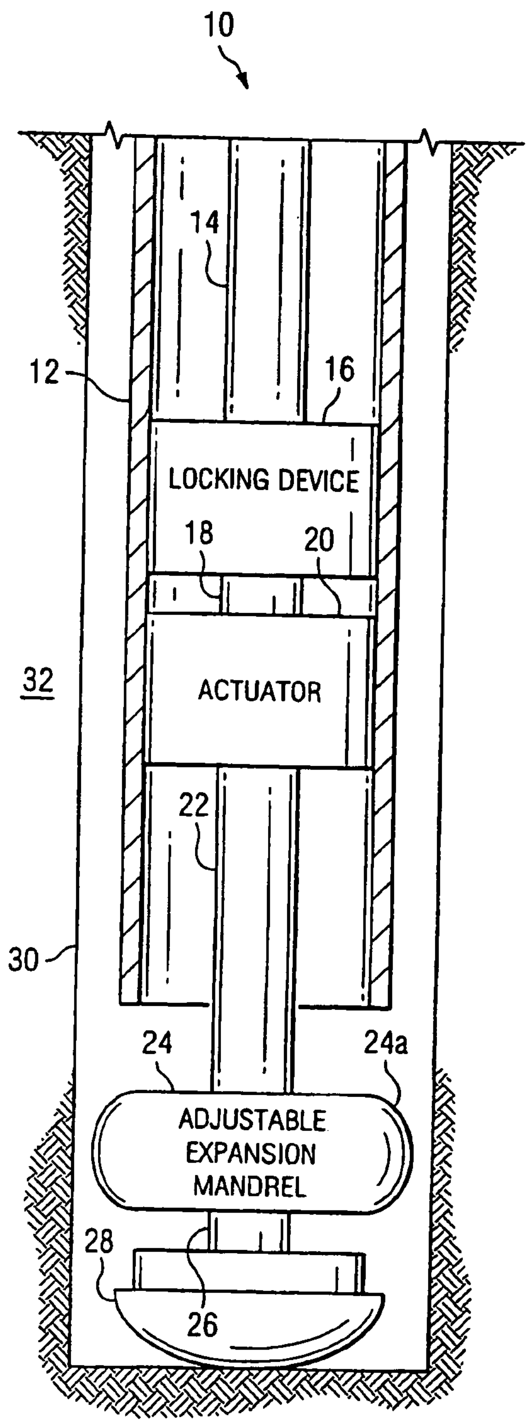
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Fig. 3

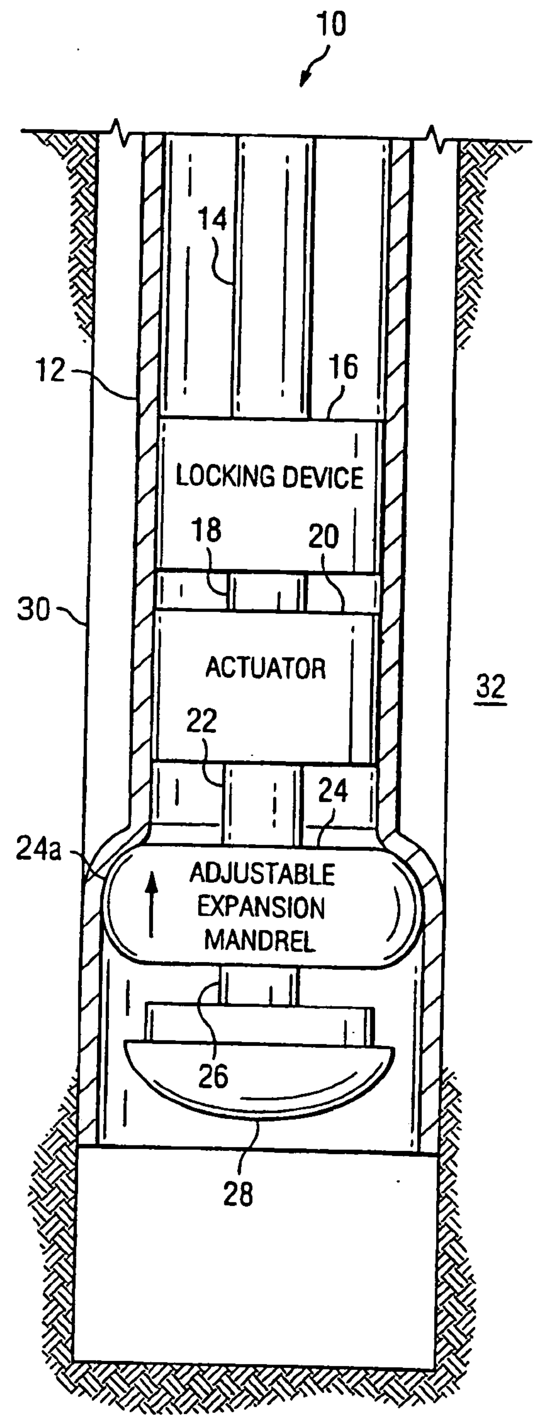
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Fig. 4

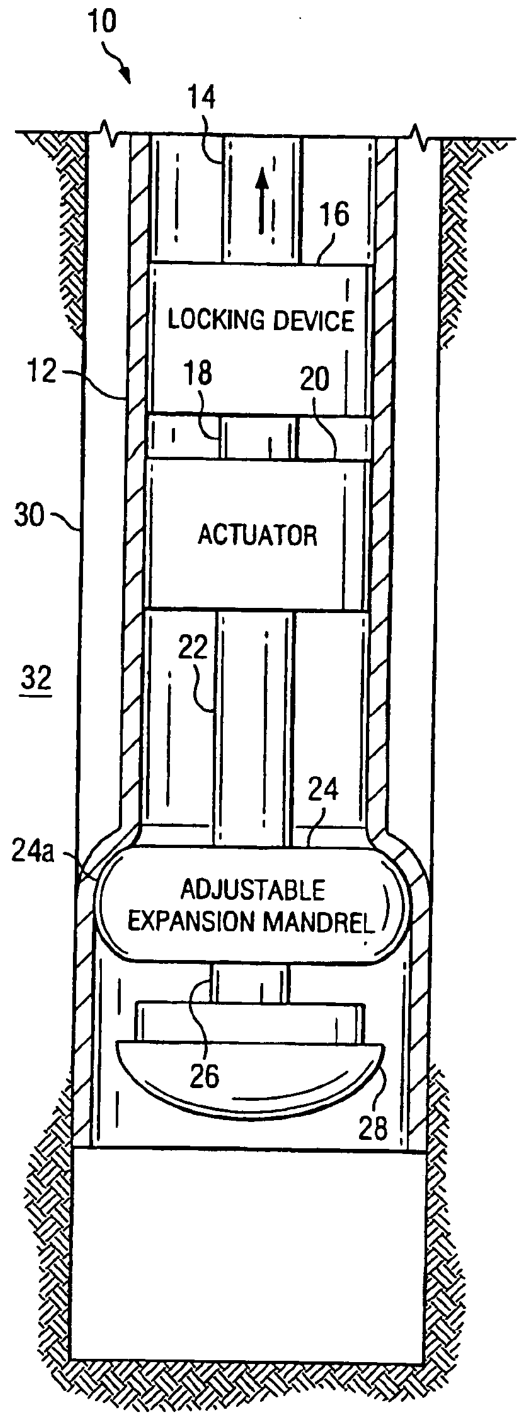
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Fig. 5

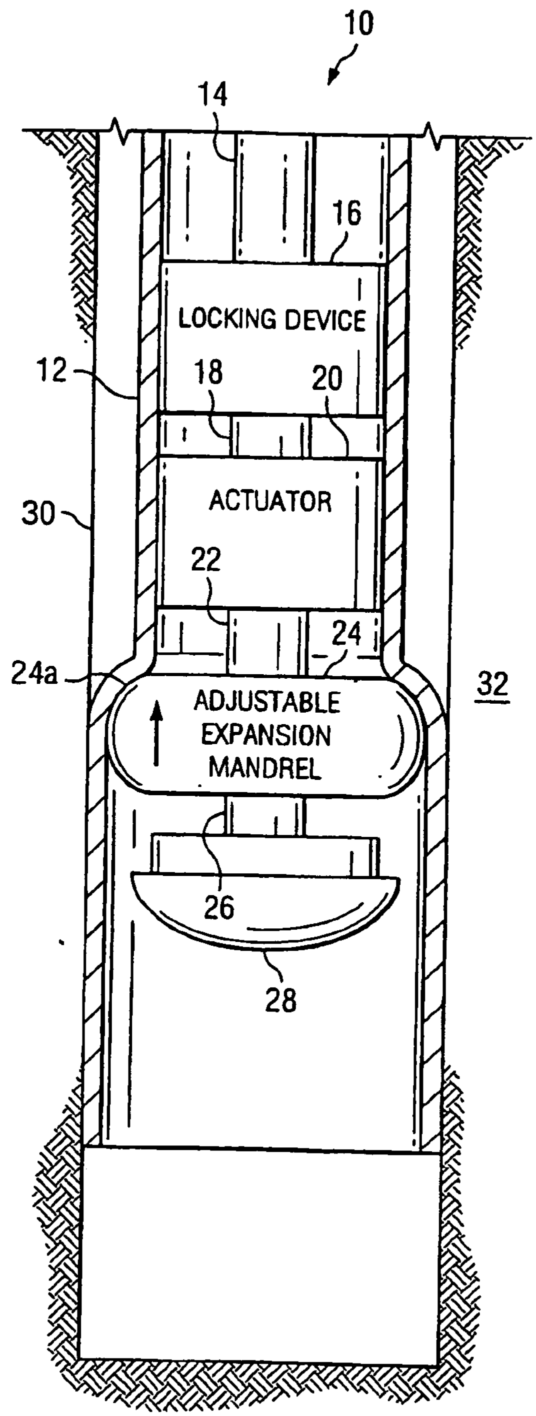
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Fig. 6

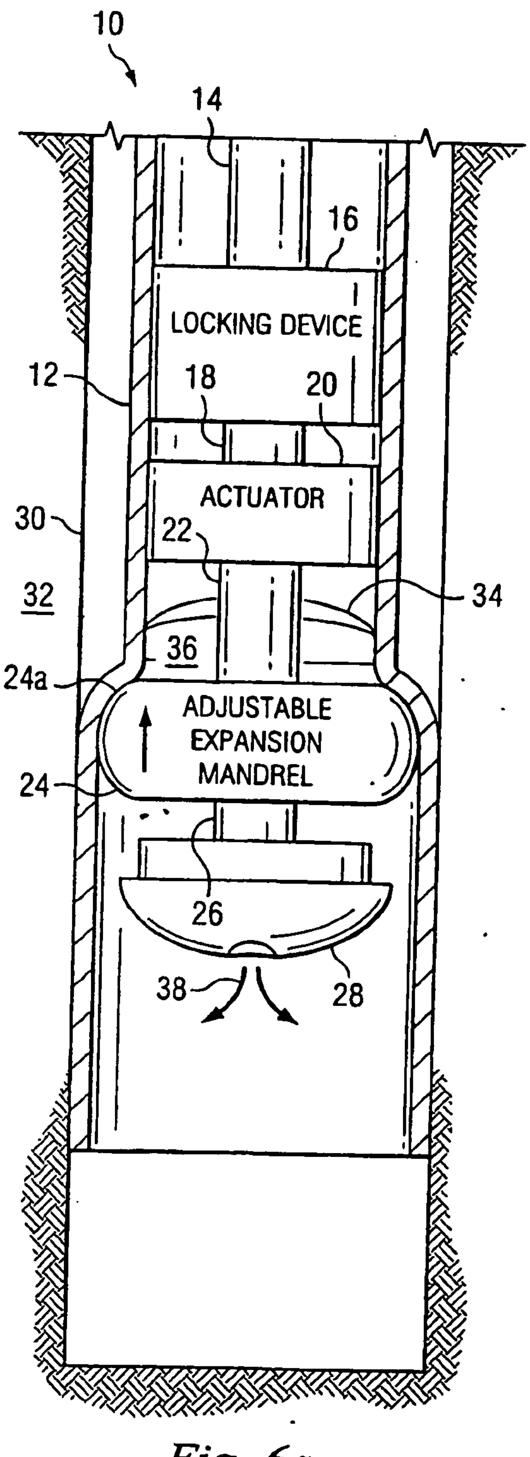
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Fig. 6a

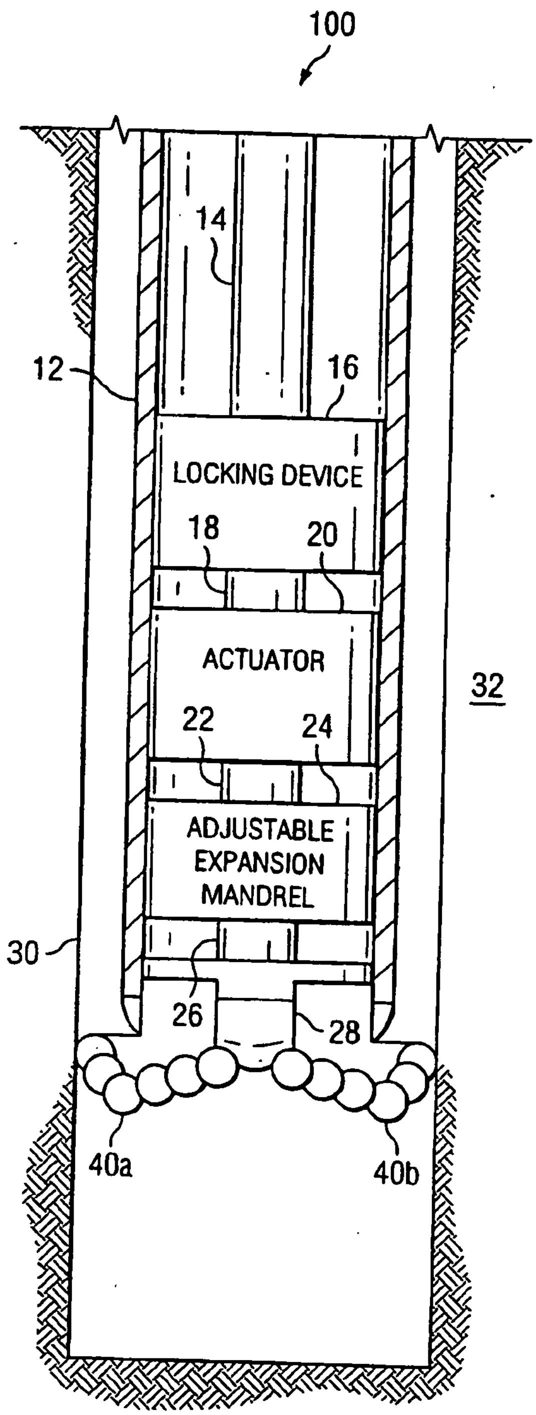
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Fig. 7

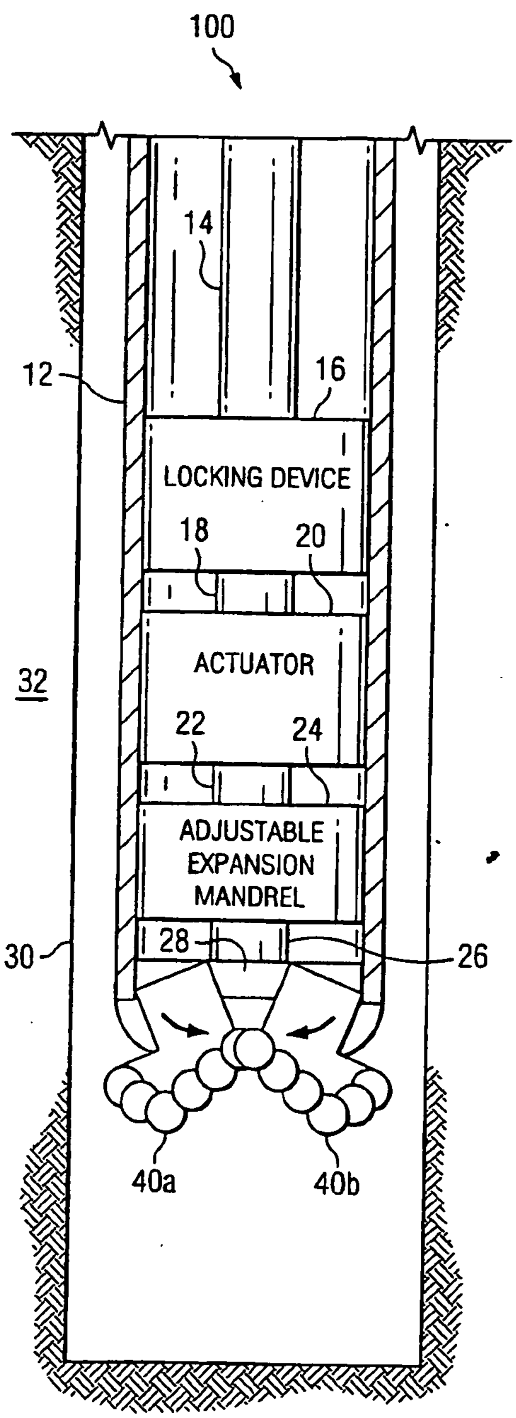
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Fig. 8

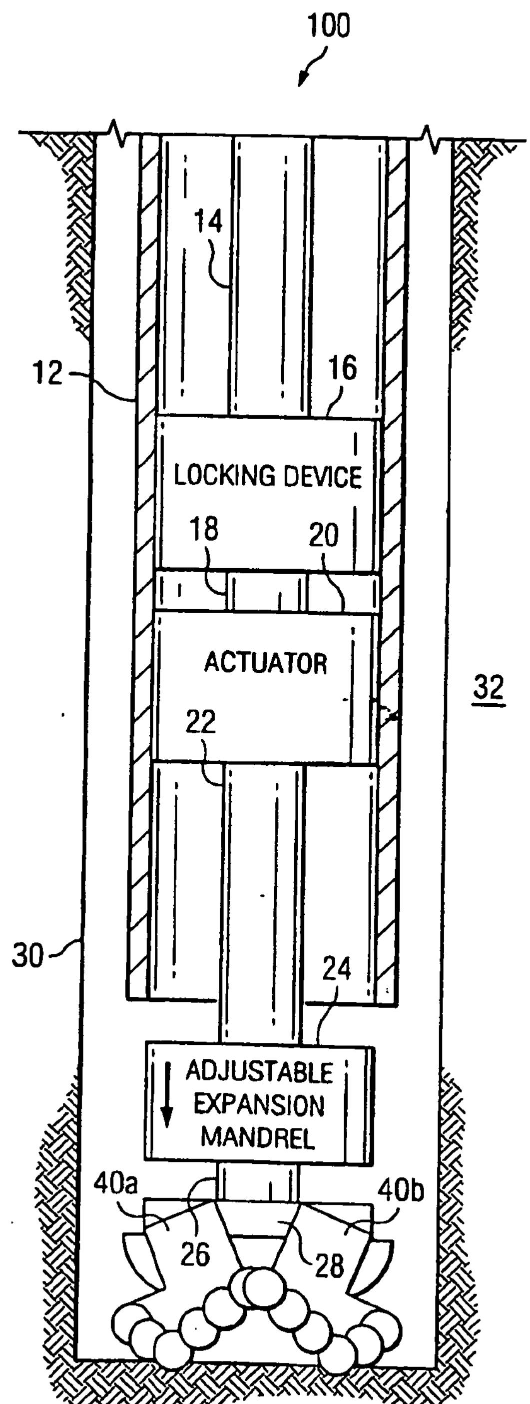
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Fig. 9

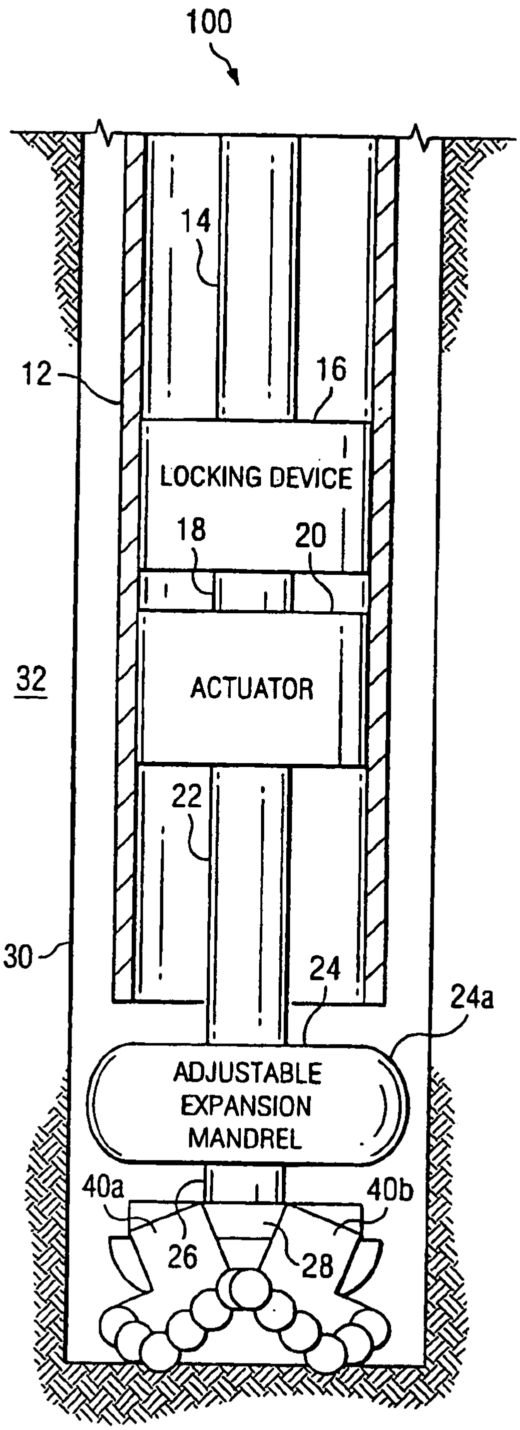
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Fig. 10

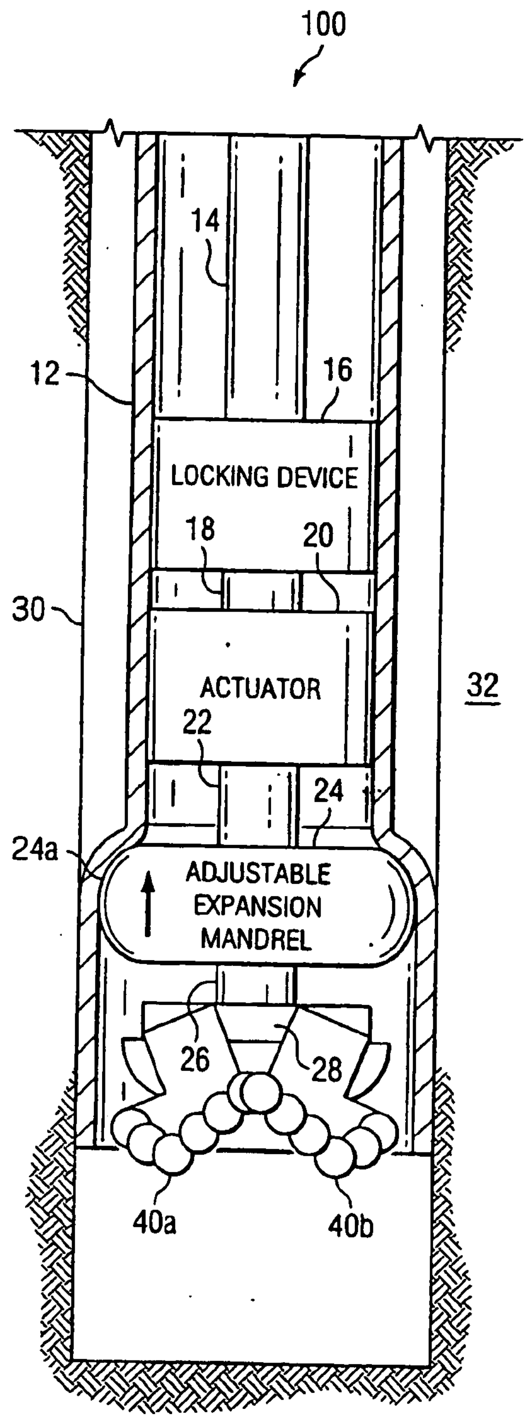
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Fig. 11

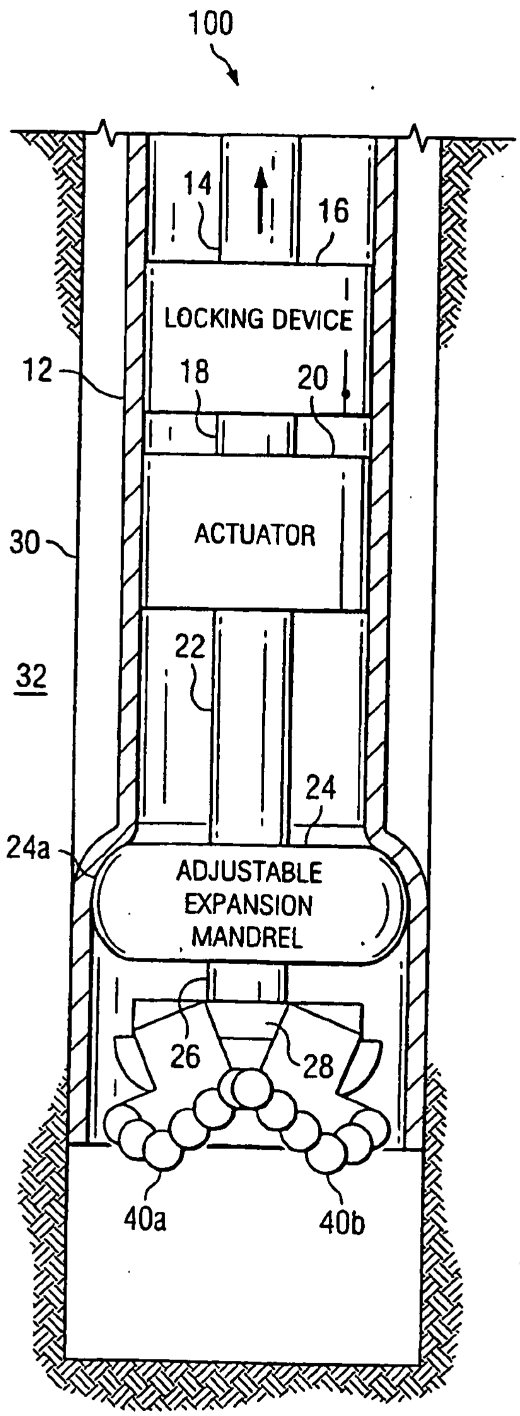
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Fig. 12

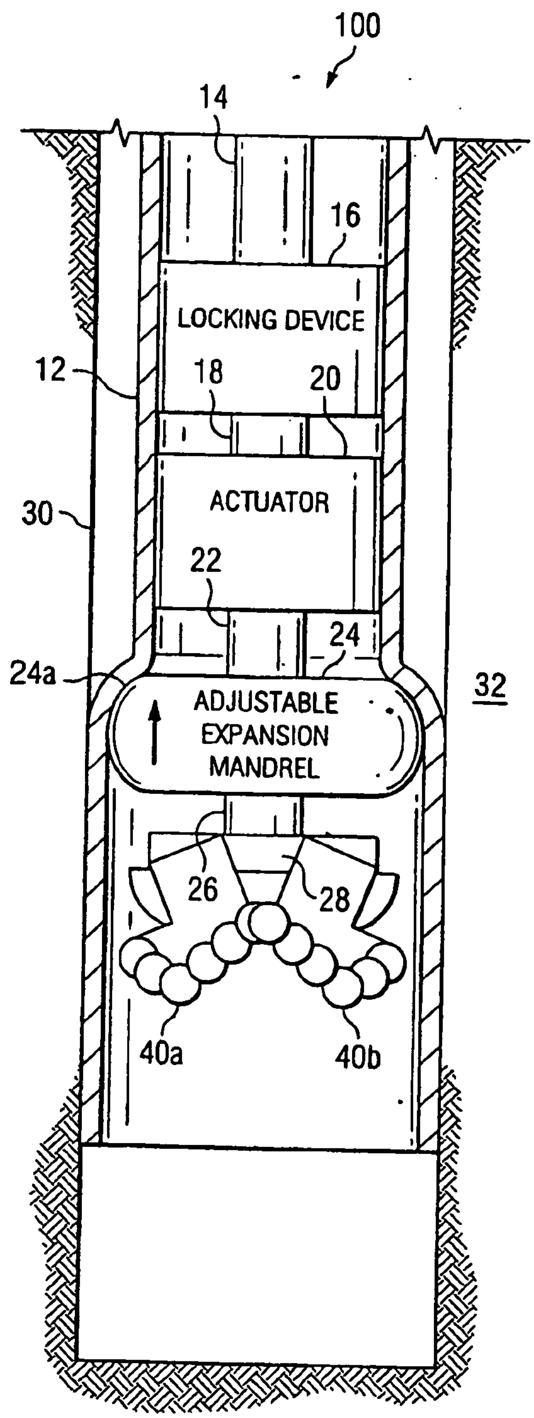
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Fig. 13

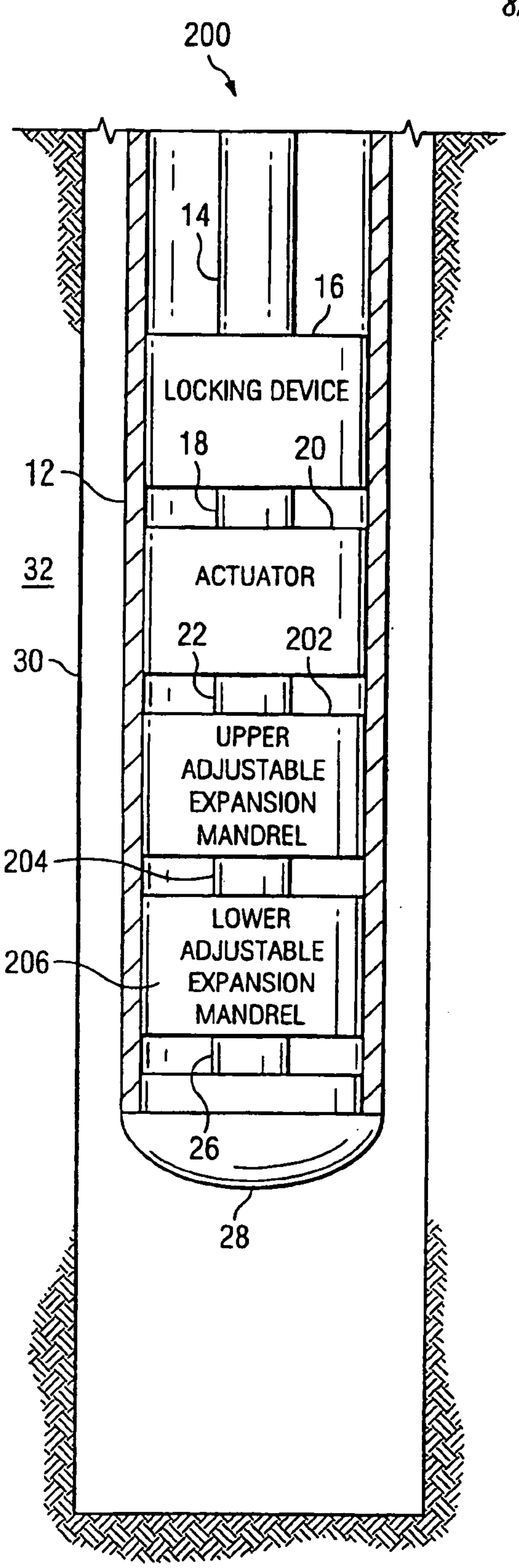
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Fig. 14

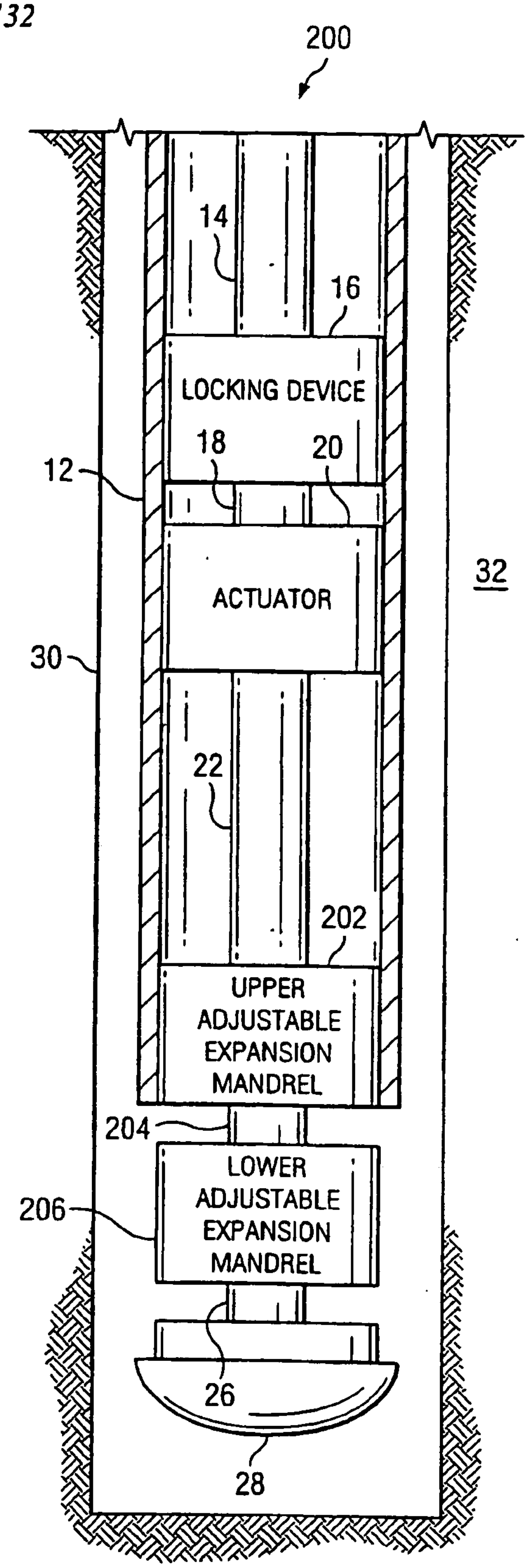
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Fig. 15

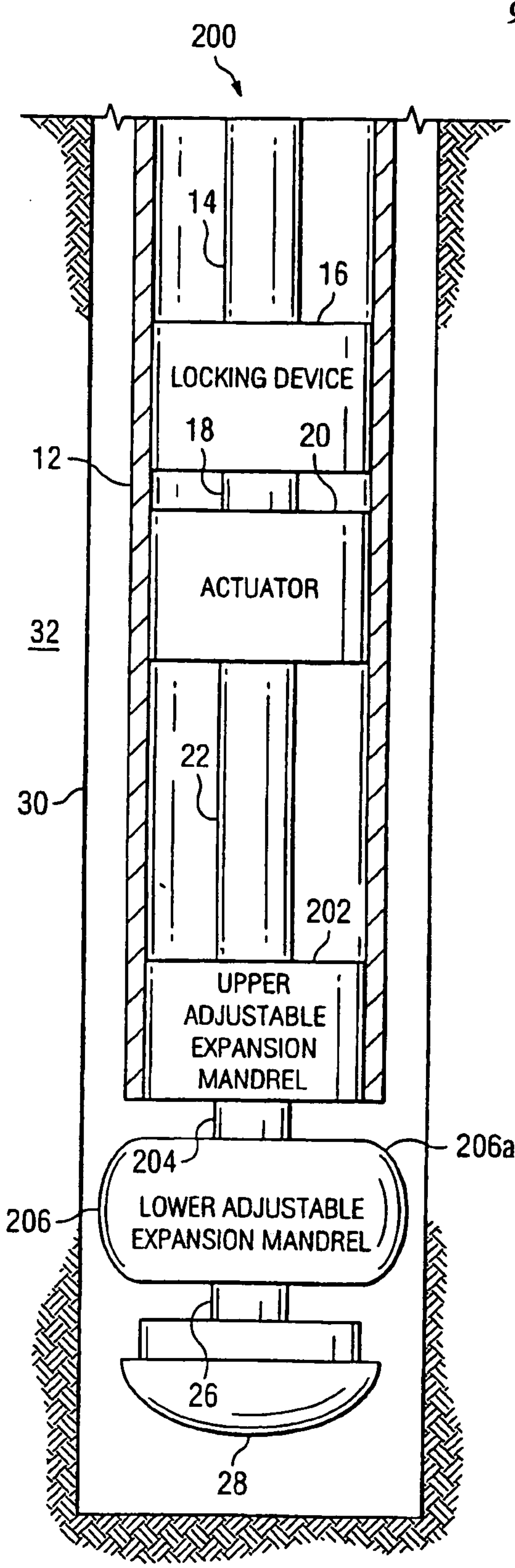
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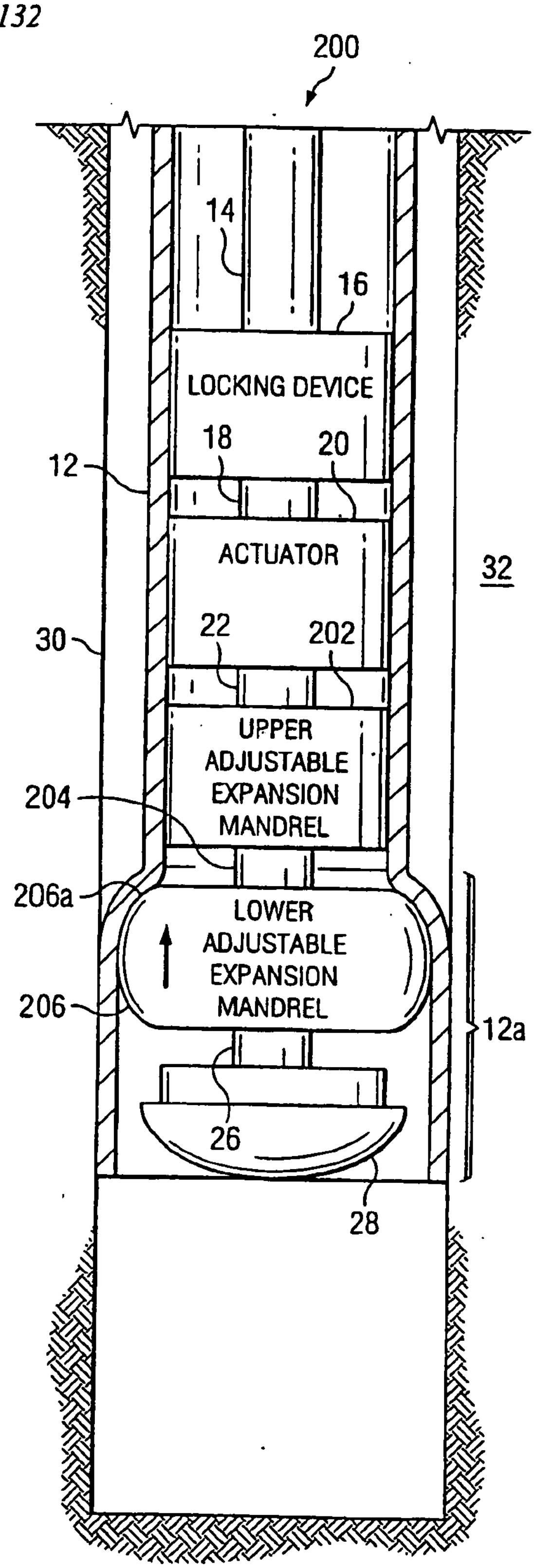
Fig. 16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LOWER ADJUSTABLE EXPANSION MANDREL
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Fig. 17

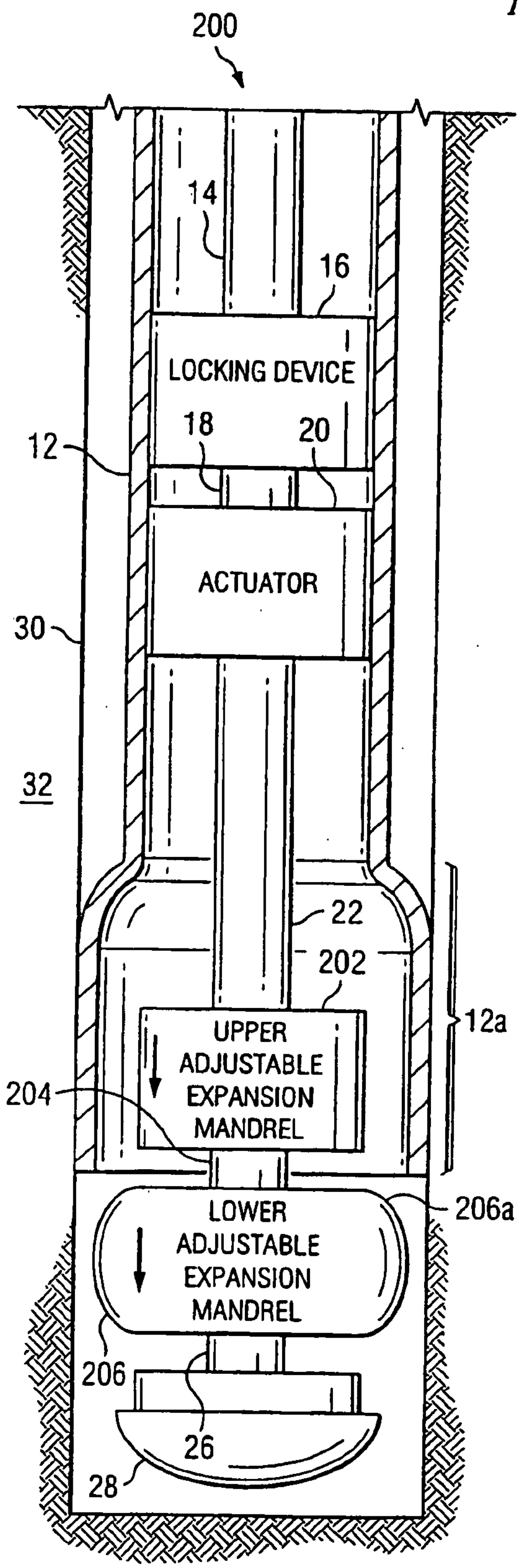
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Fig. 18

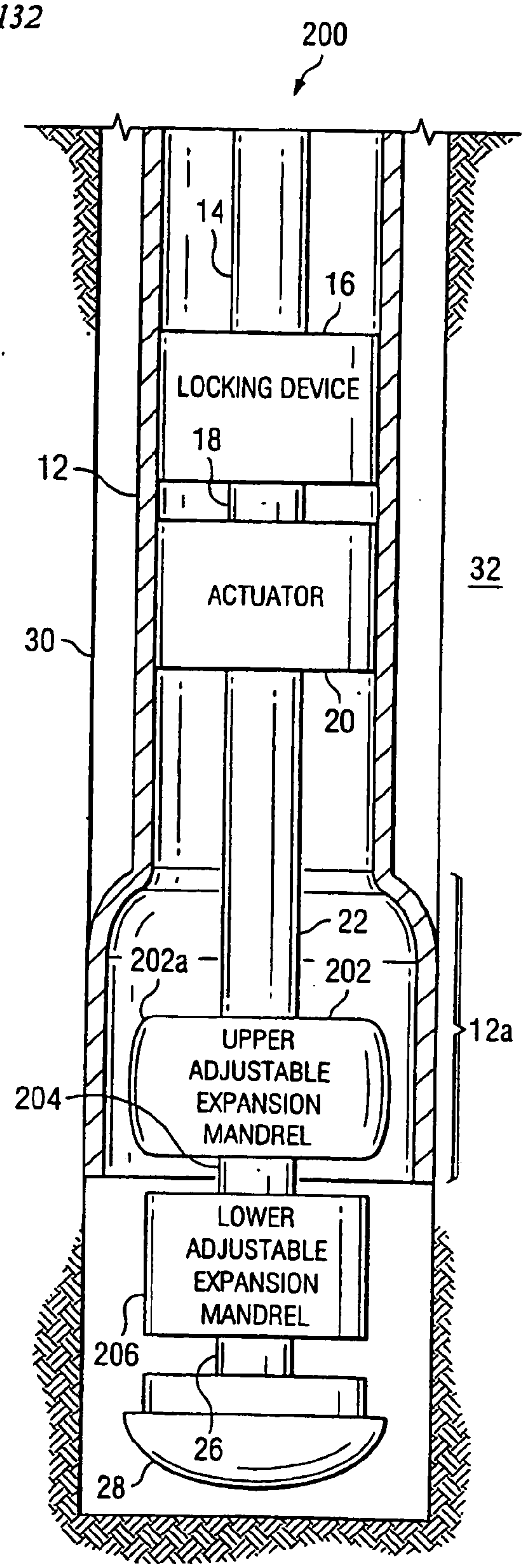
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Fig. 19

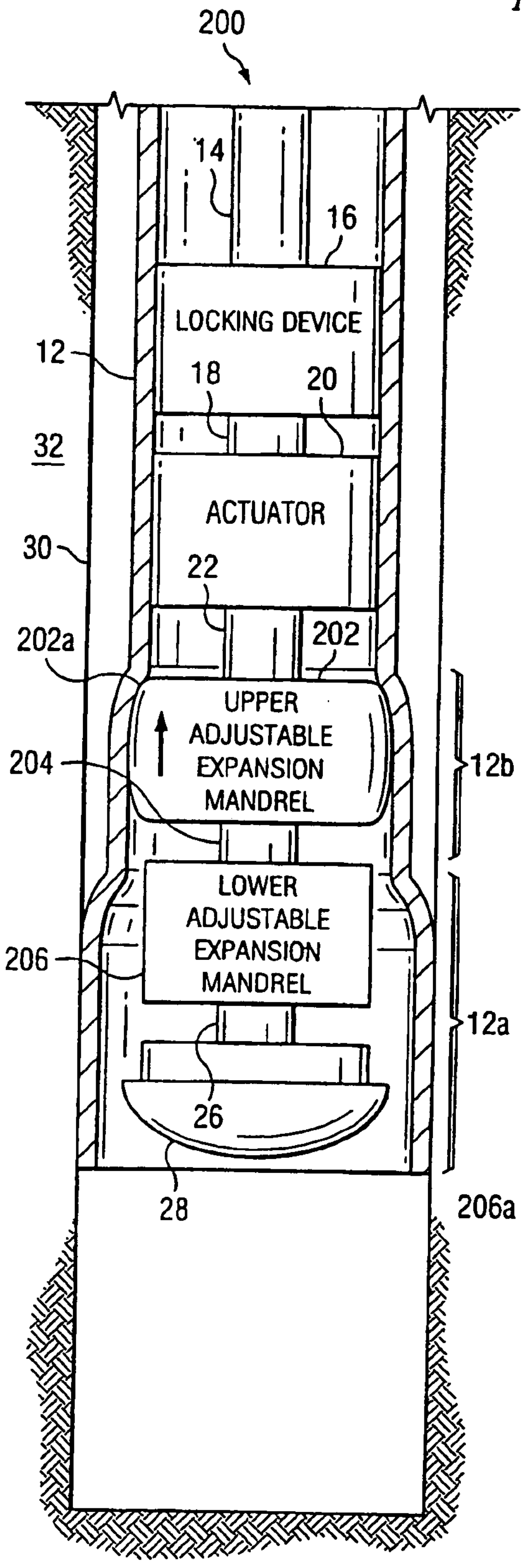
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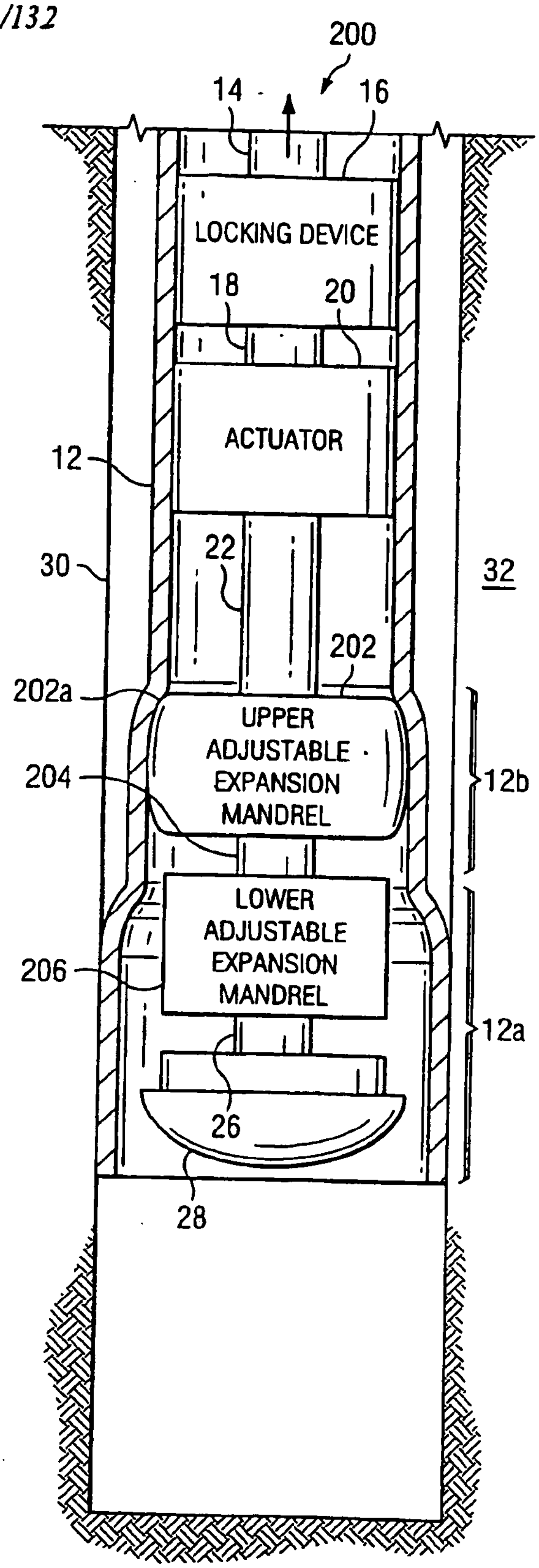
Fig. 20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LOWER ADJUSTABLE EXPANSION MANDREL
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12a
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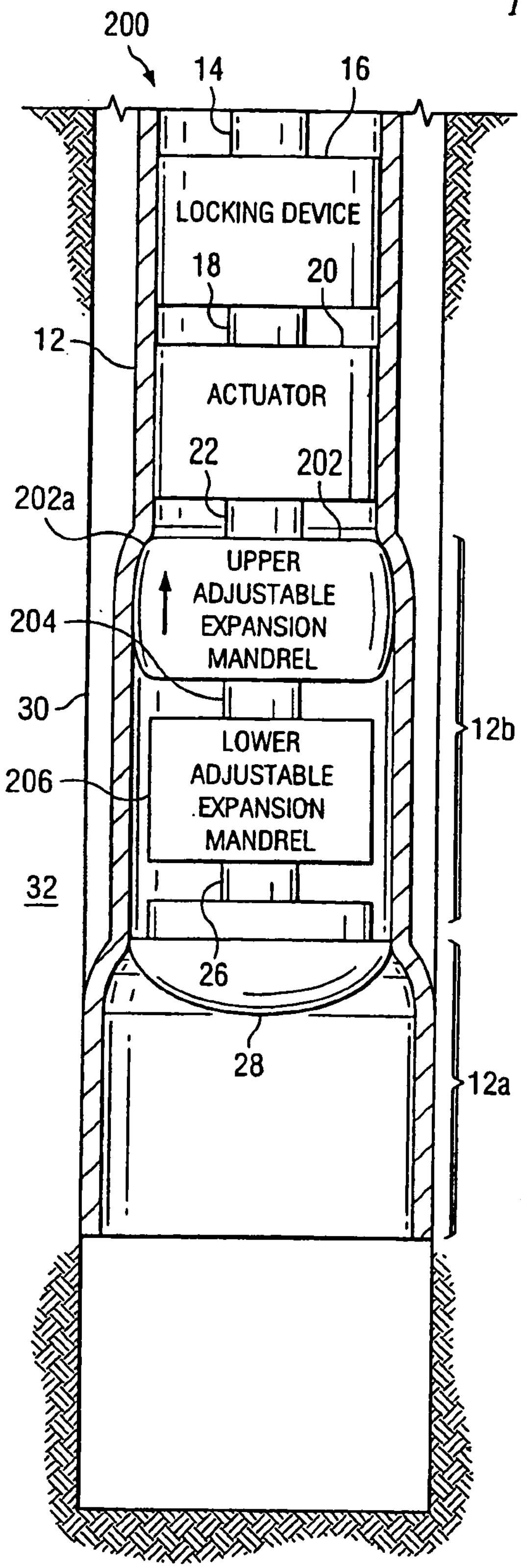
Fig. 21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EXPANSION
MANDREL
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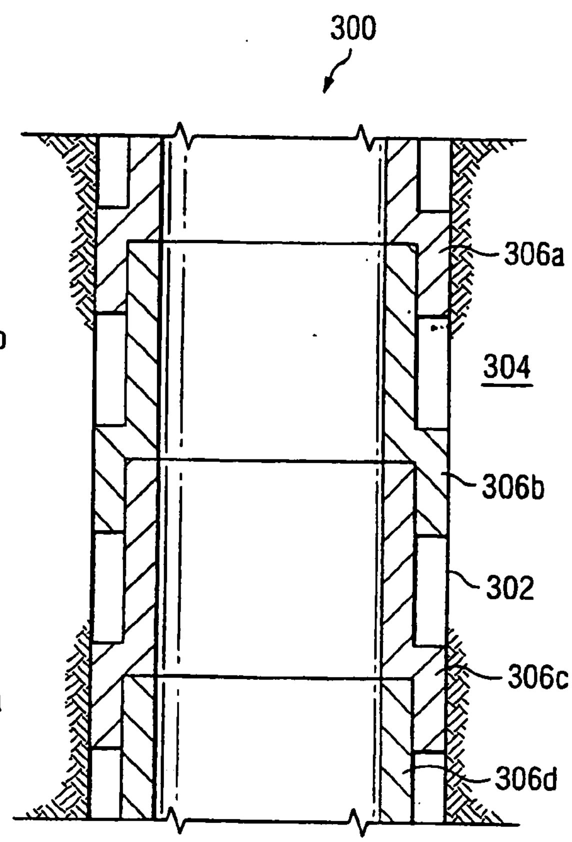
Fig. 22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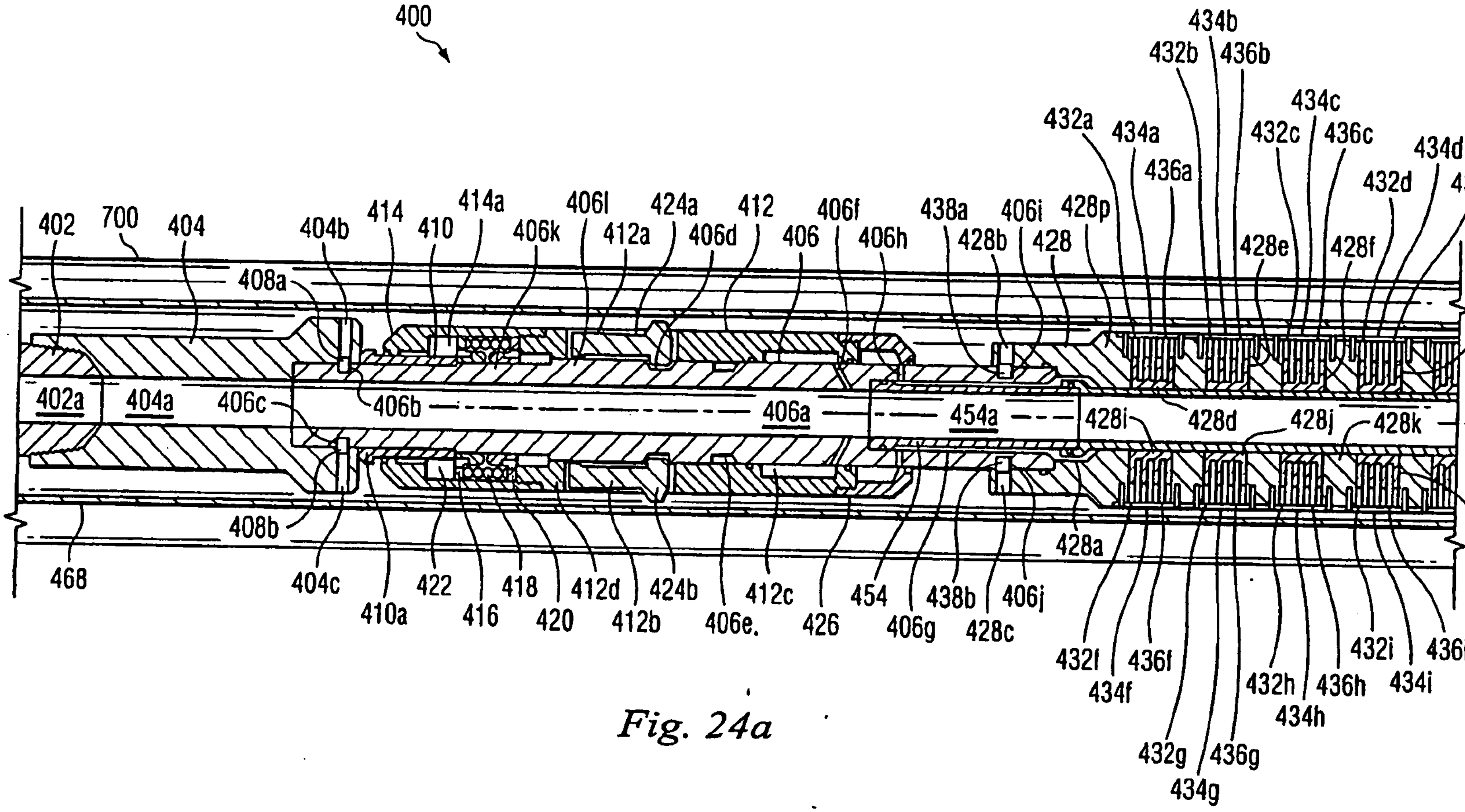
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406i
428
428p
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432b
434b
436b
428e
432c
434c
436c
428f
432d
434d
436d
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404a
406c
406b
406a
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428i
428d
428j
428k
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404c
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416
418
420
412d
412b
424b
406e.
412c
426
454
406g
438b
428c
406j
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Fig. 24a

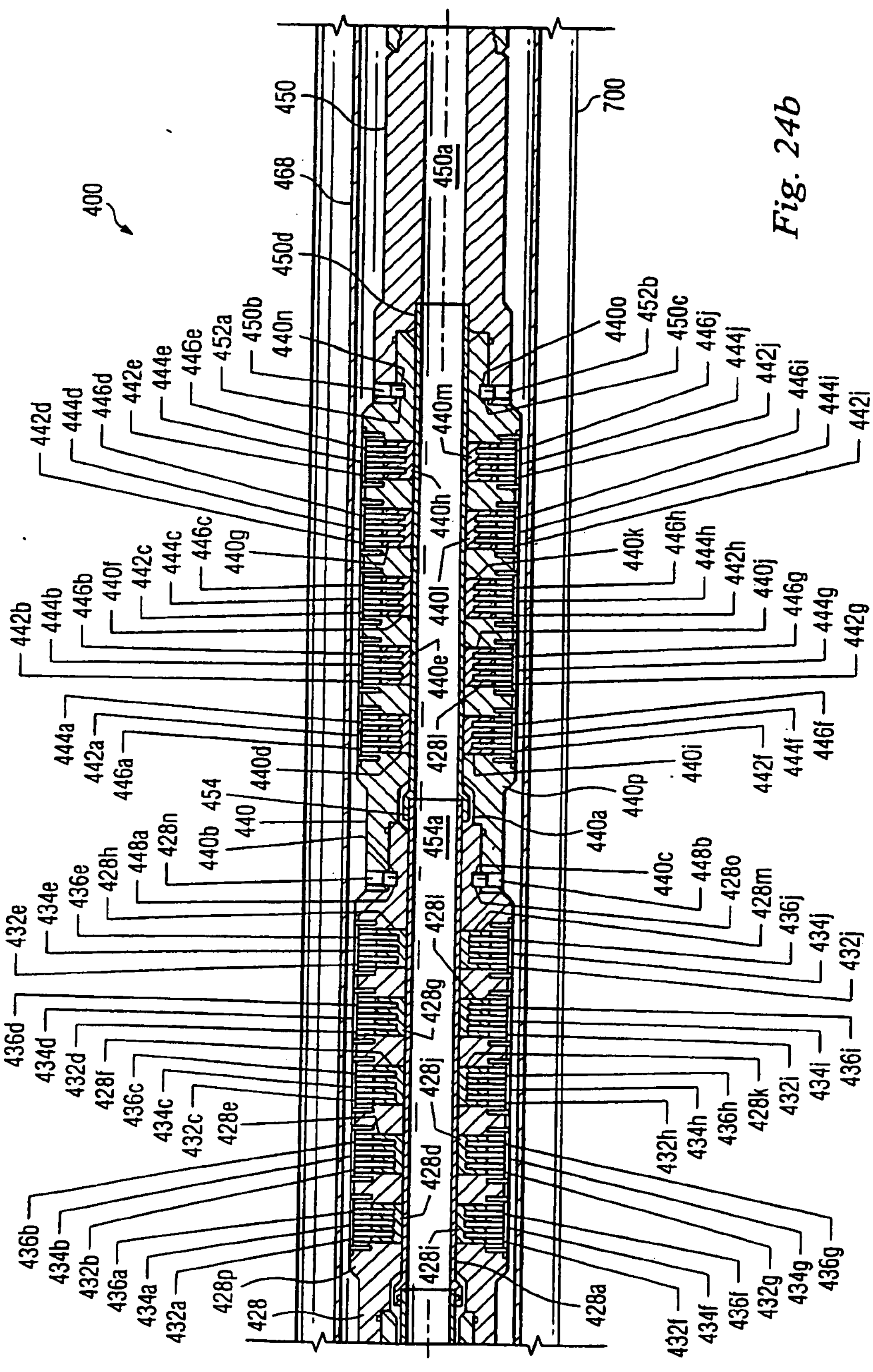
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Fig. 24b

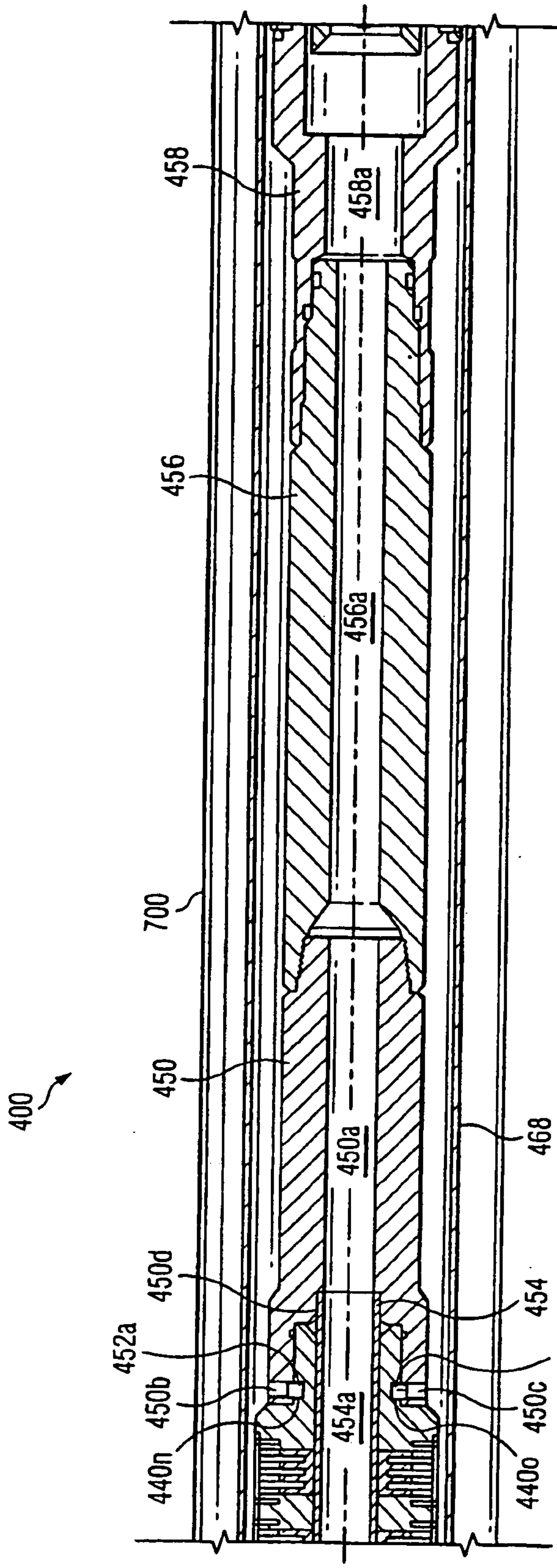
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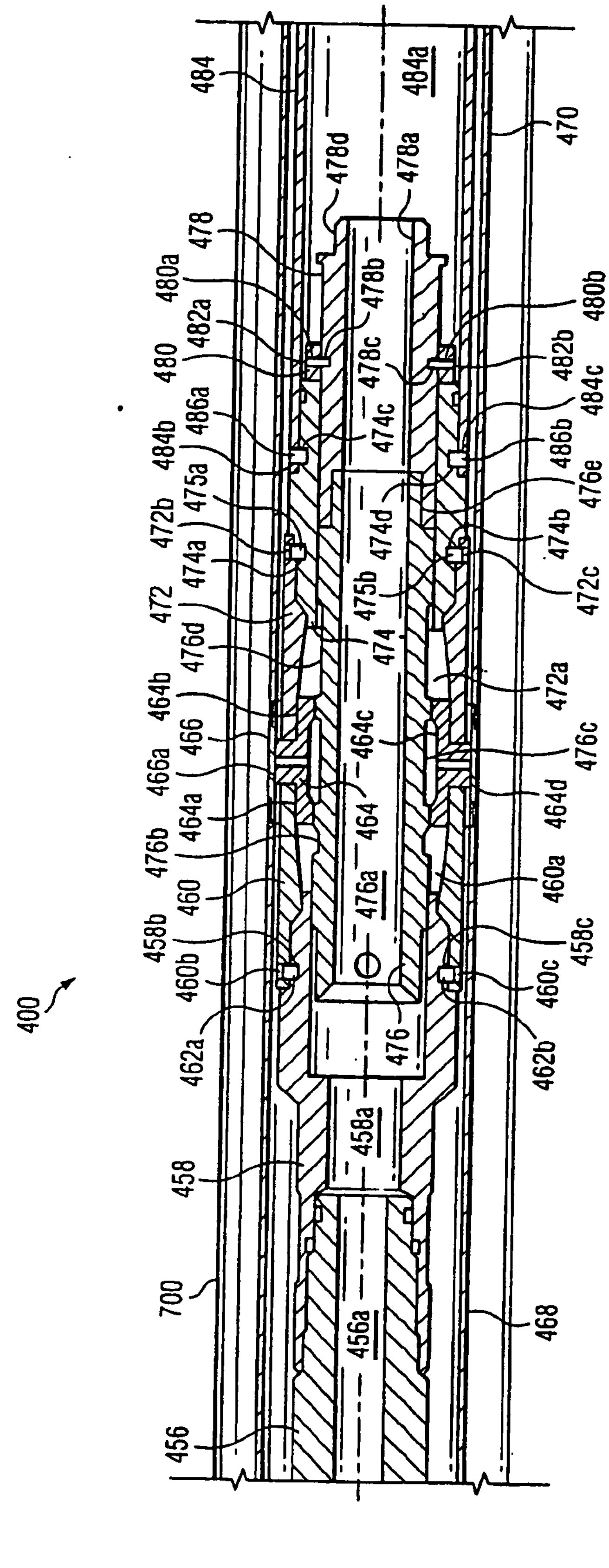
Fig. 24c



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476b
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Fig: 24d

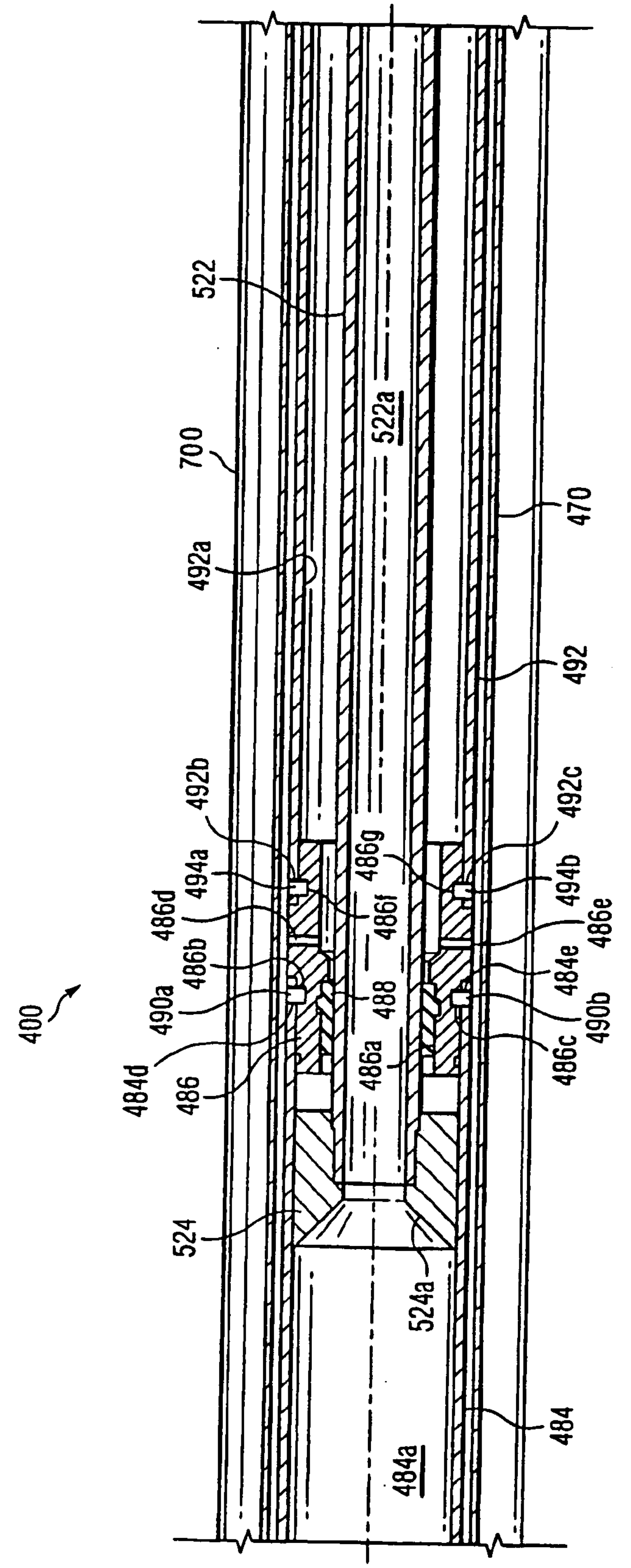

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Fig. 24e

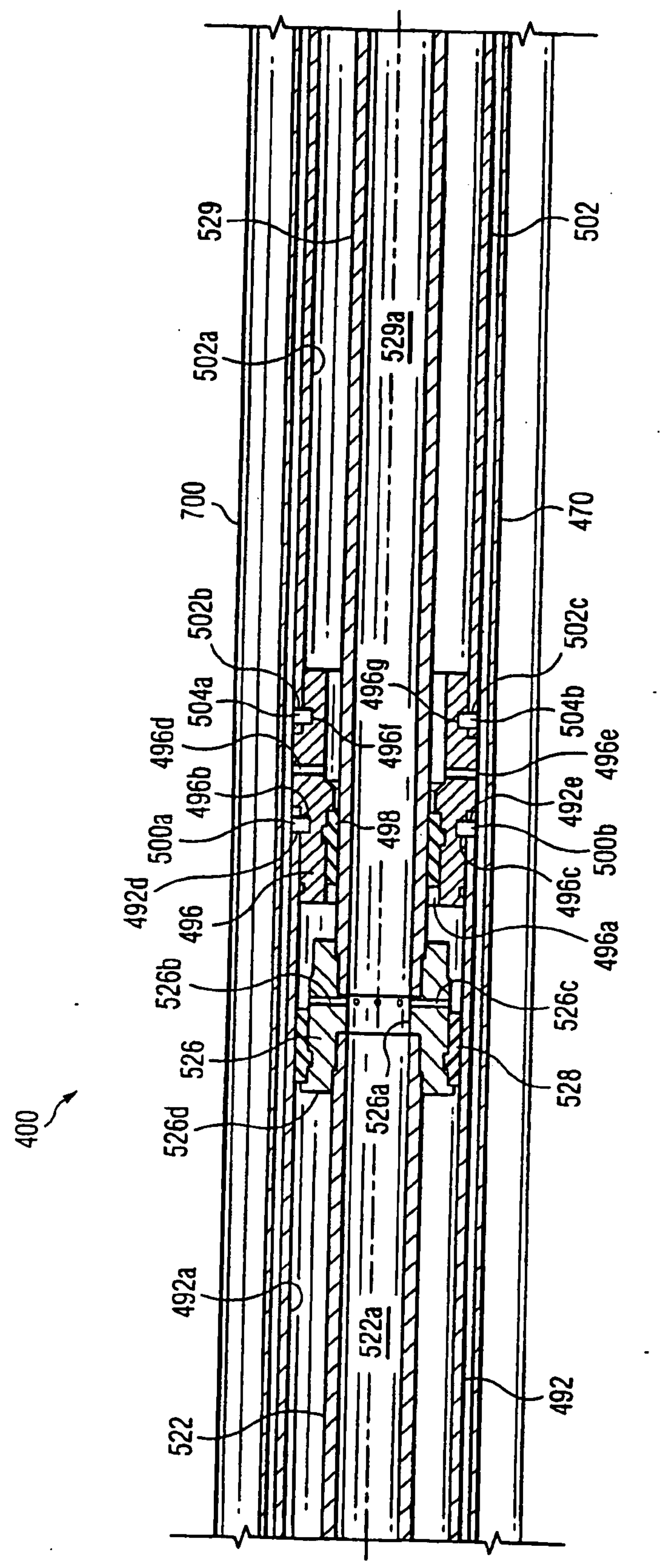
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Fig. 24f

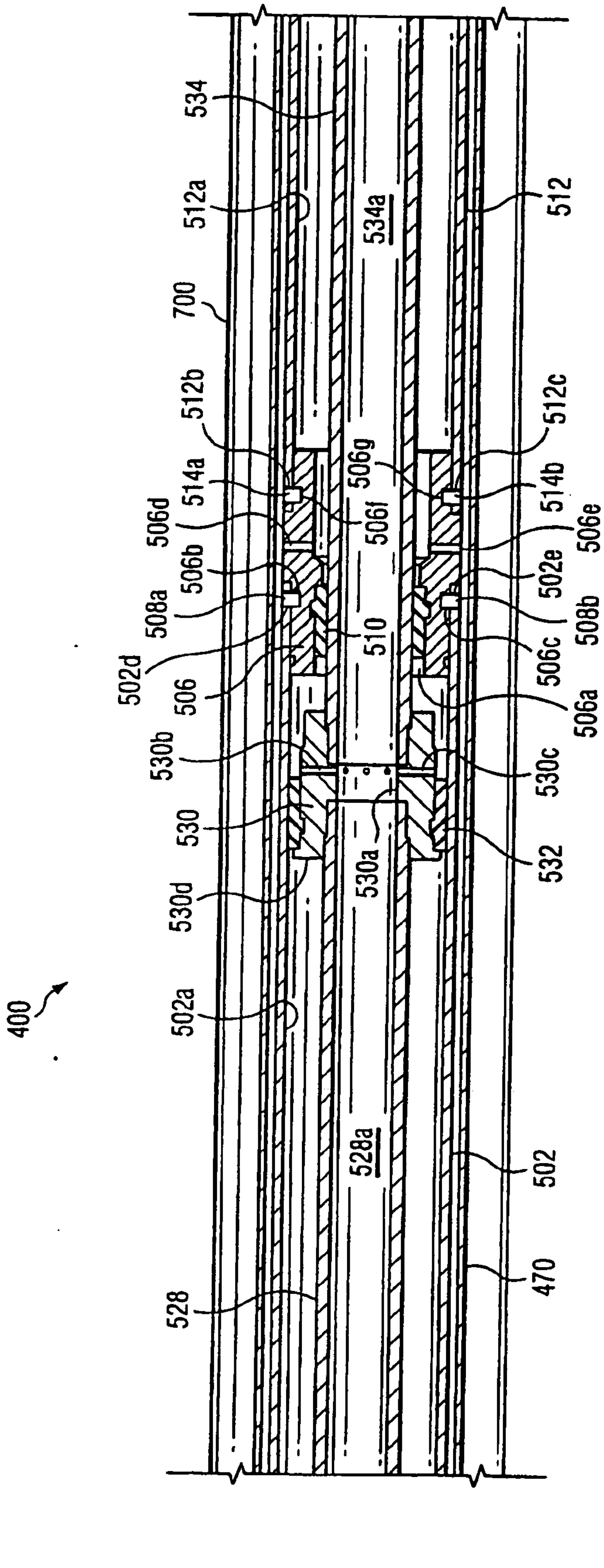
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Fig. 24g

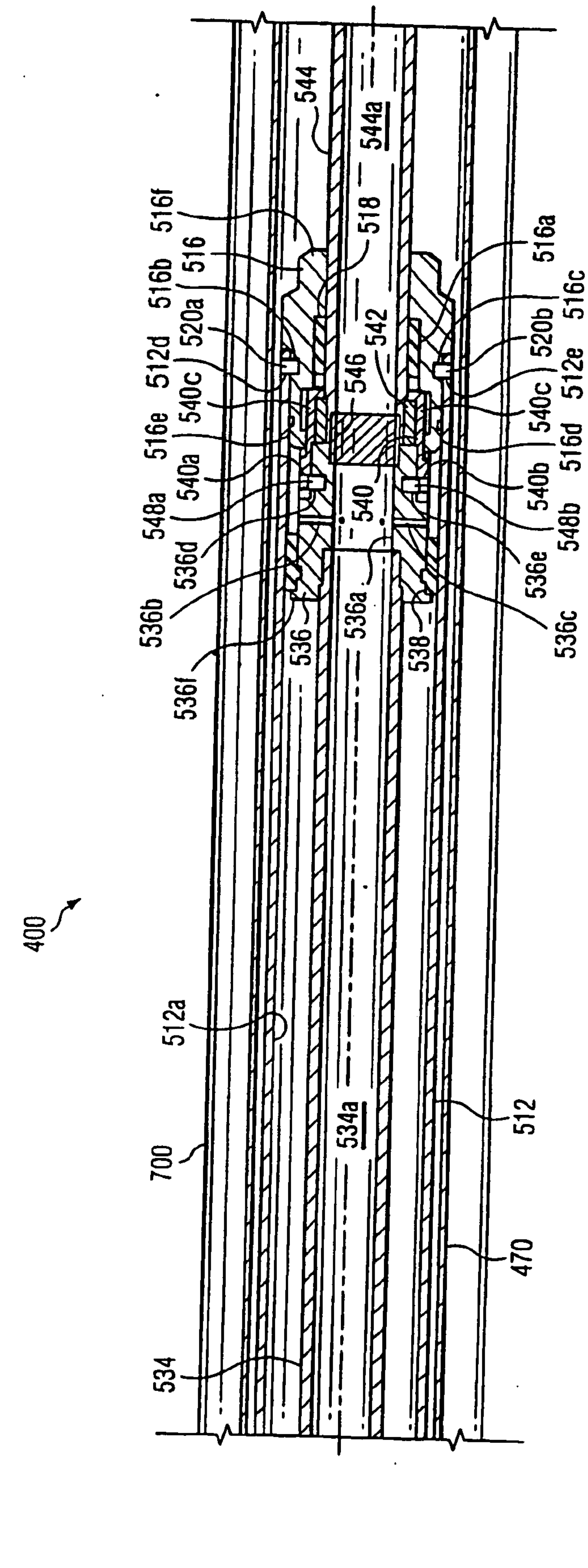
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Fig. 24h

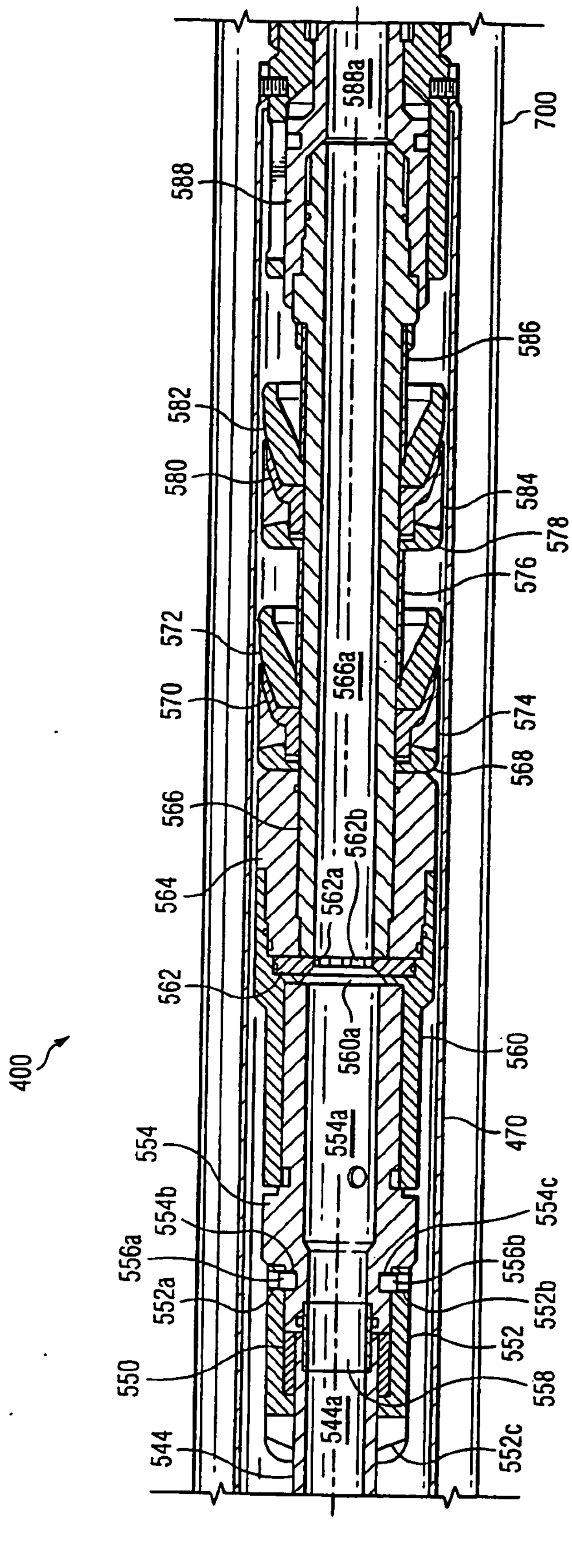

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Fig. 24i

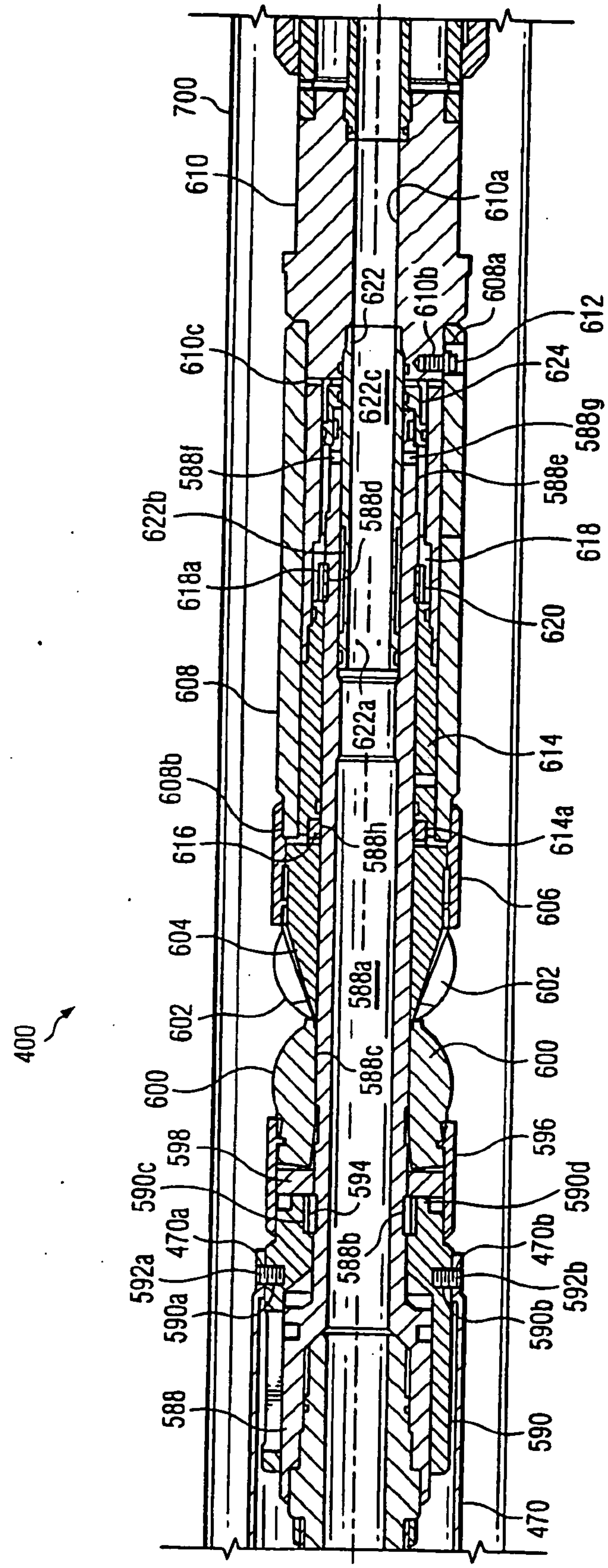

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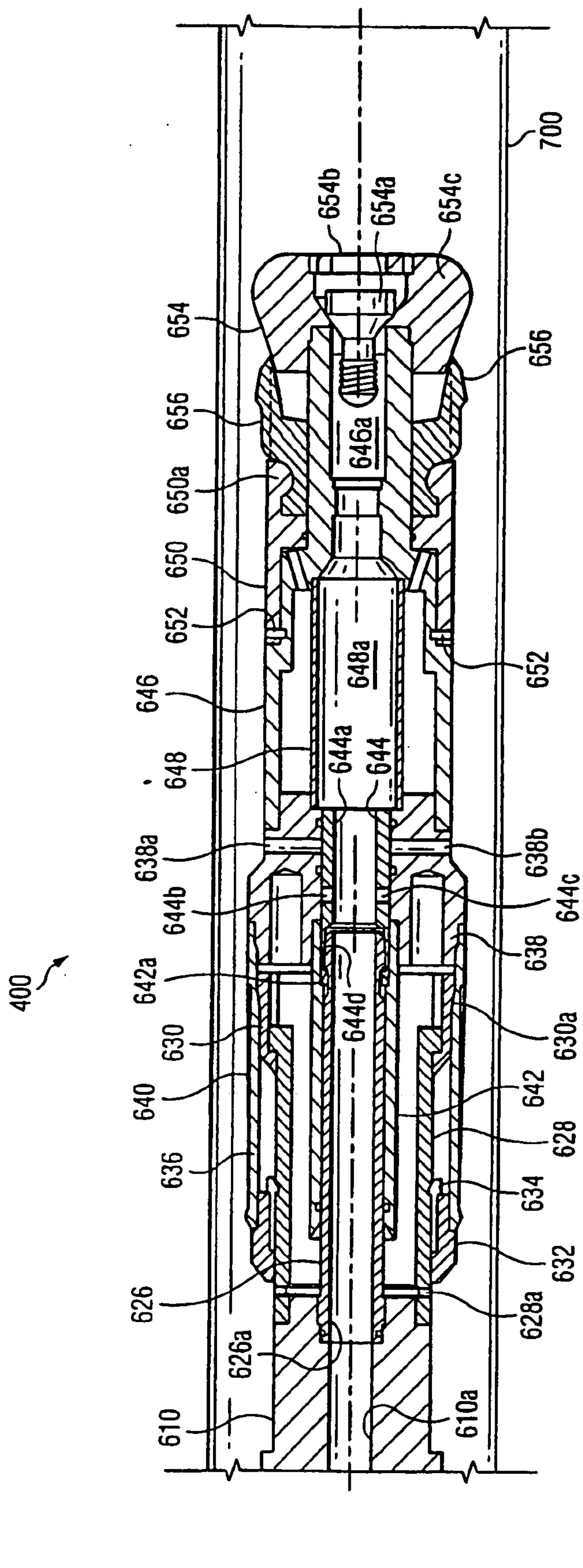
Fig. 24j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638a
638b
644b
644c
638
400
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630a
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626a
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610a

Fig. 24k

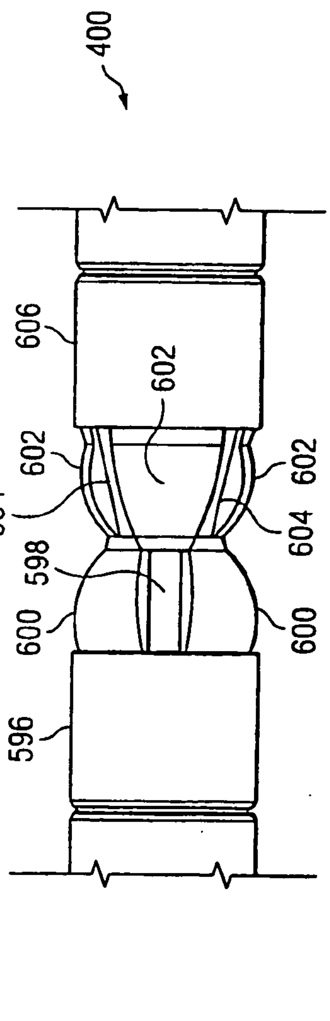


Fig. 25a

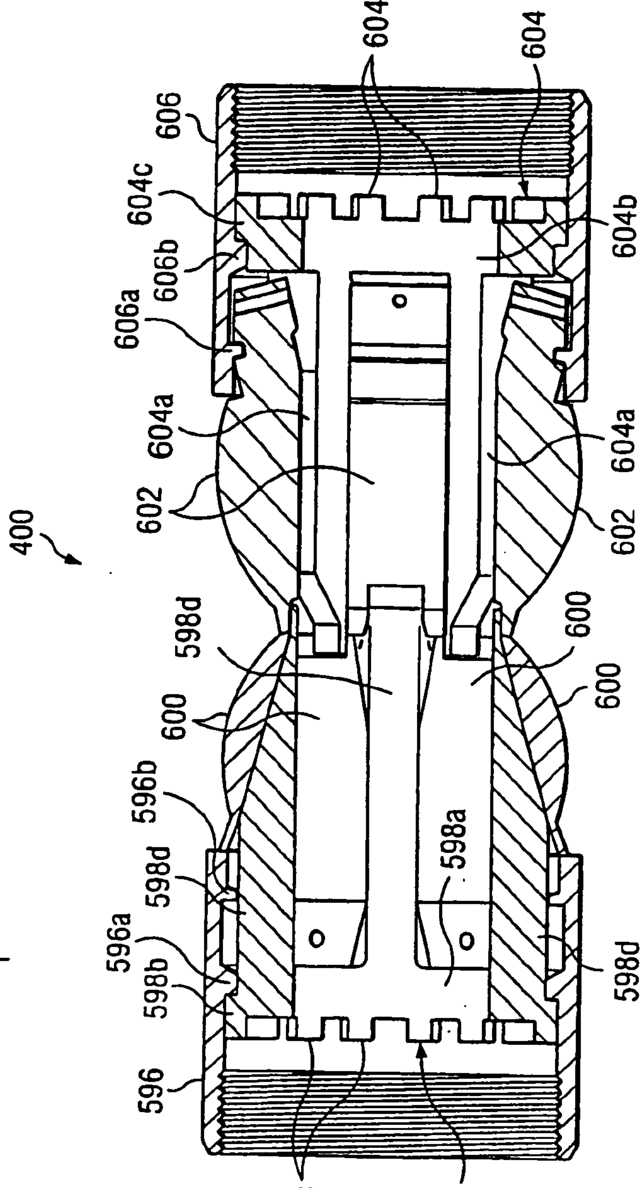


FIG. 25b

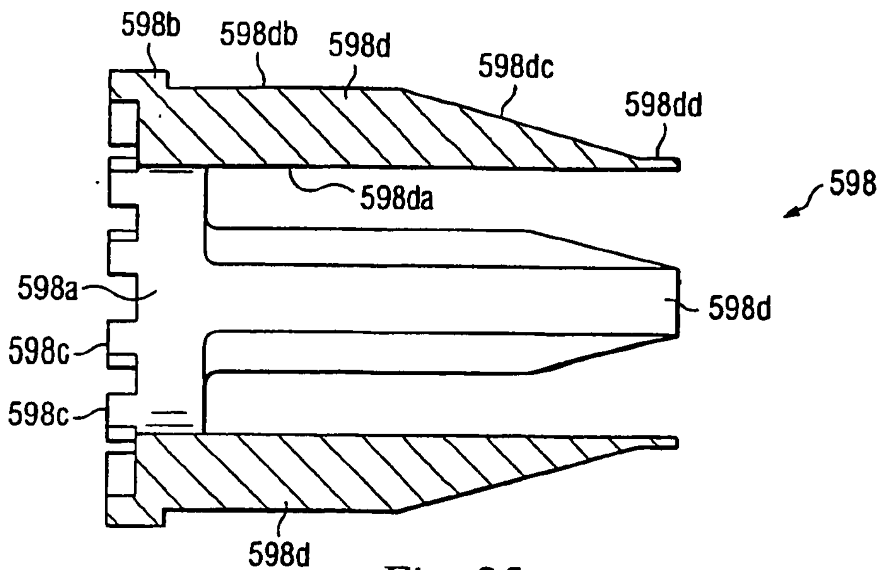


Fig. 25c

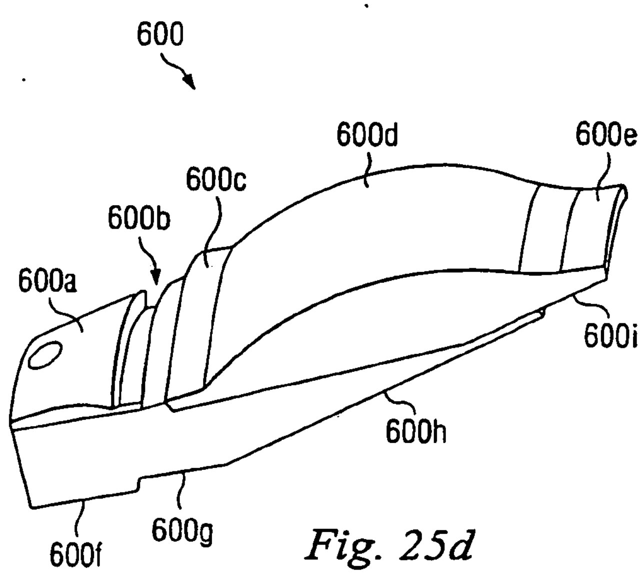


Fig. 25d

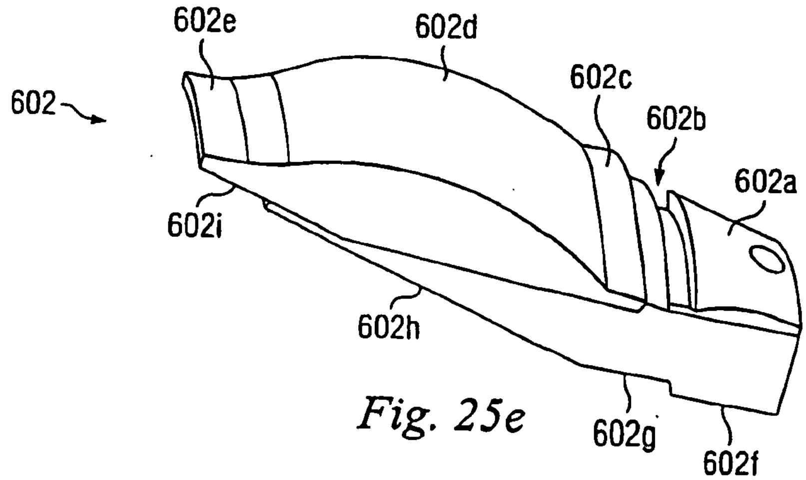


Fig. 25e

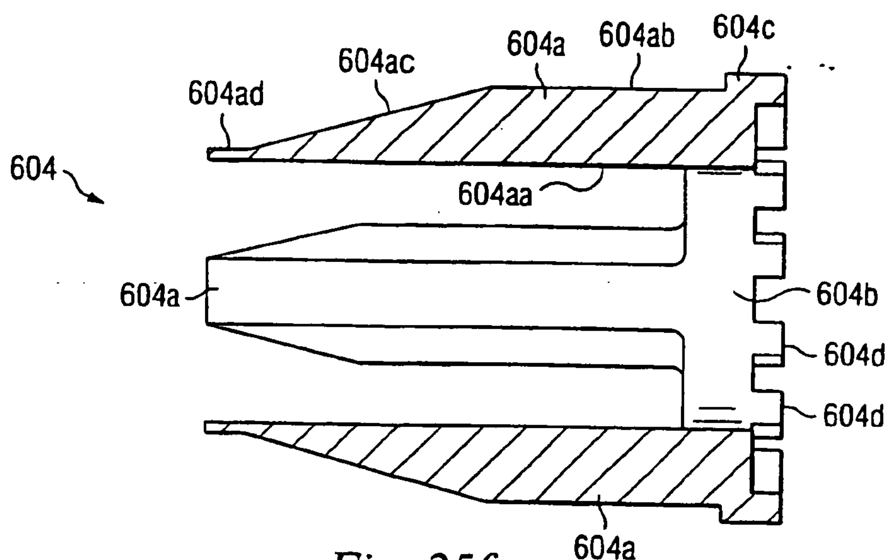


Fig. 25f

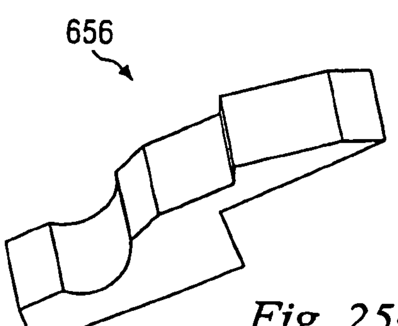
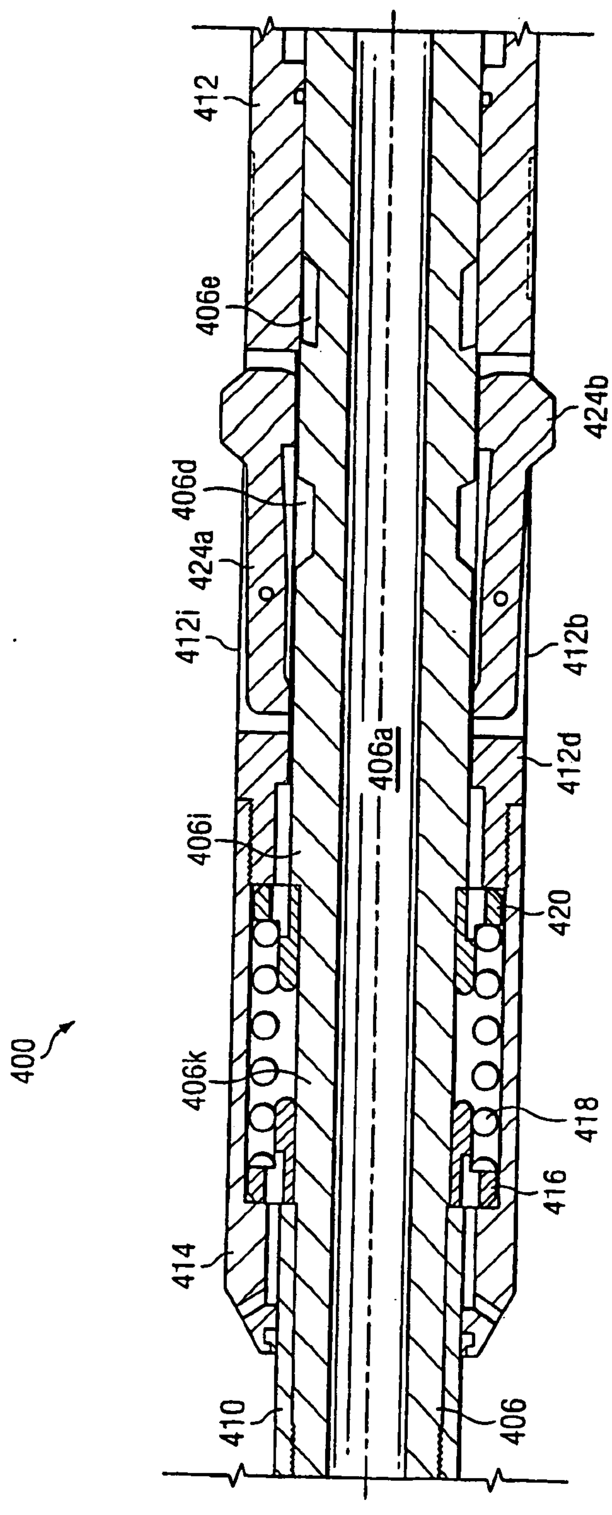


Fig. 25g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406e
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406k
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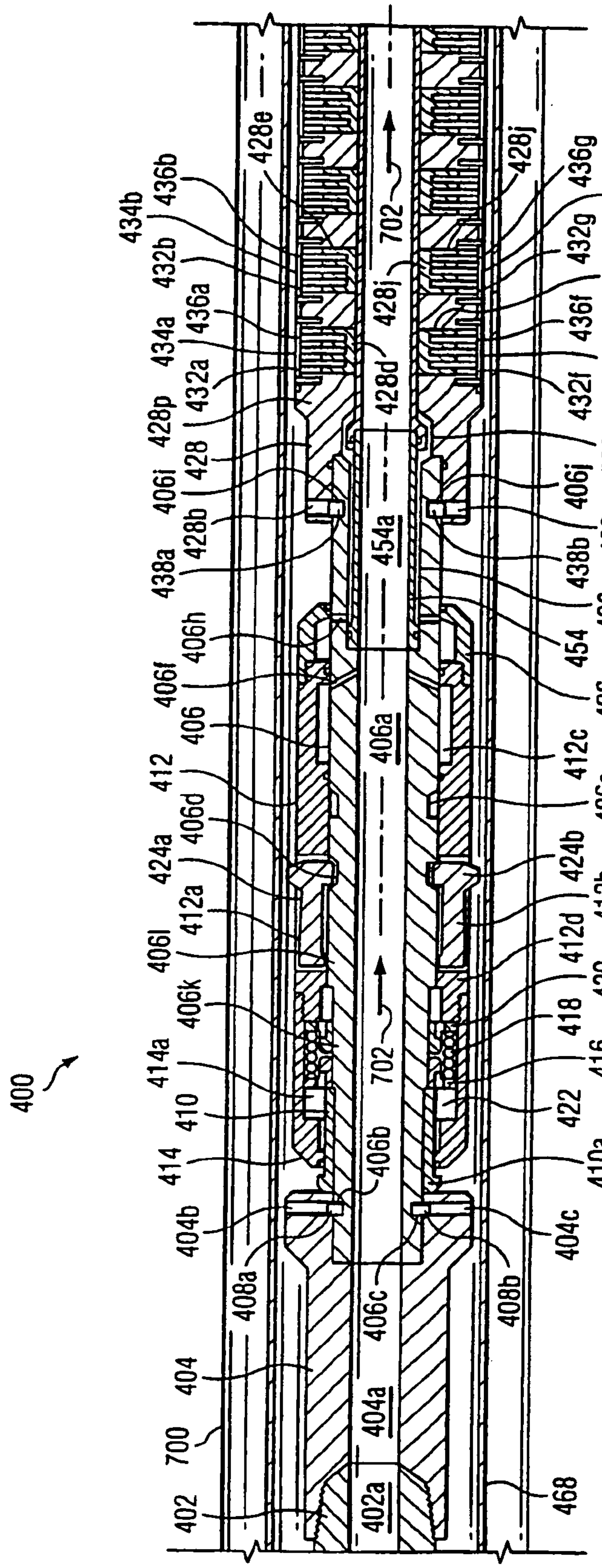
Fig. 25h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406j
406k
406l
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408b
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410a
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412a
412b
412c
412d
414
414a
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418
420
422
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424b
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428a
428b
428c
428d
428e
428i
428j
428p
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432f
432g
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438b
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454a
468
700
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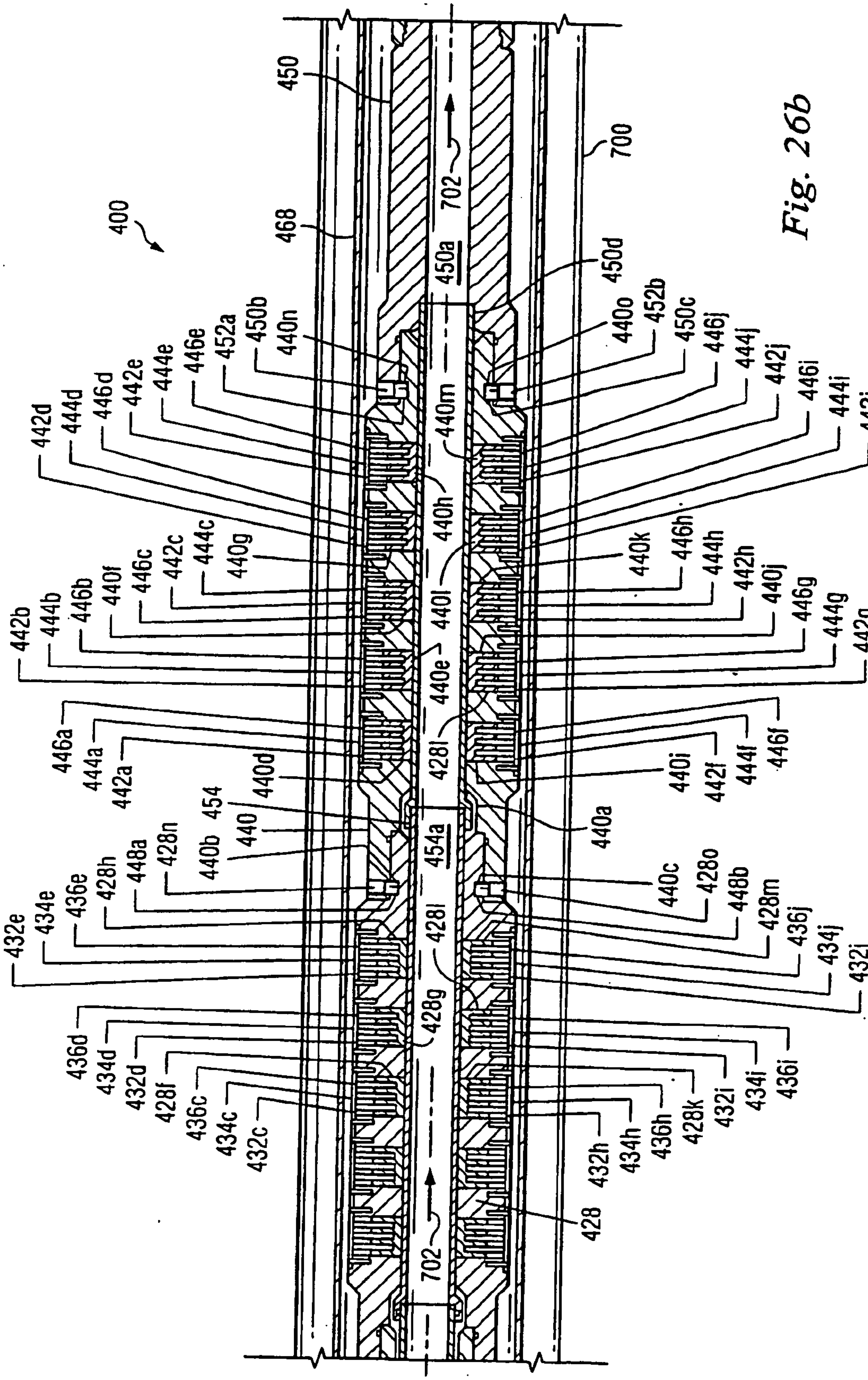
Fig. 26a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444j
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446i
444i
442i
440m
440h
440k
446h
444h
442h
440j
446g
444g
442g
440g
444c
442c
446c
440f
446b
444b
442b
440l
440e
428l
446a
444a
442a
440d
454
440
440b
428n
448a
428h
436e
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440i
442f
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440c
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436j
434j
432j
428i
428g
436d
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432c
436i
434i
432i
428k
436h
434h
432h
428

Fig. 26b

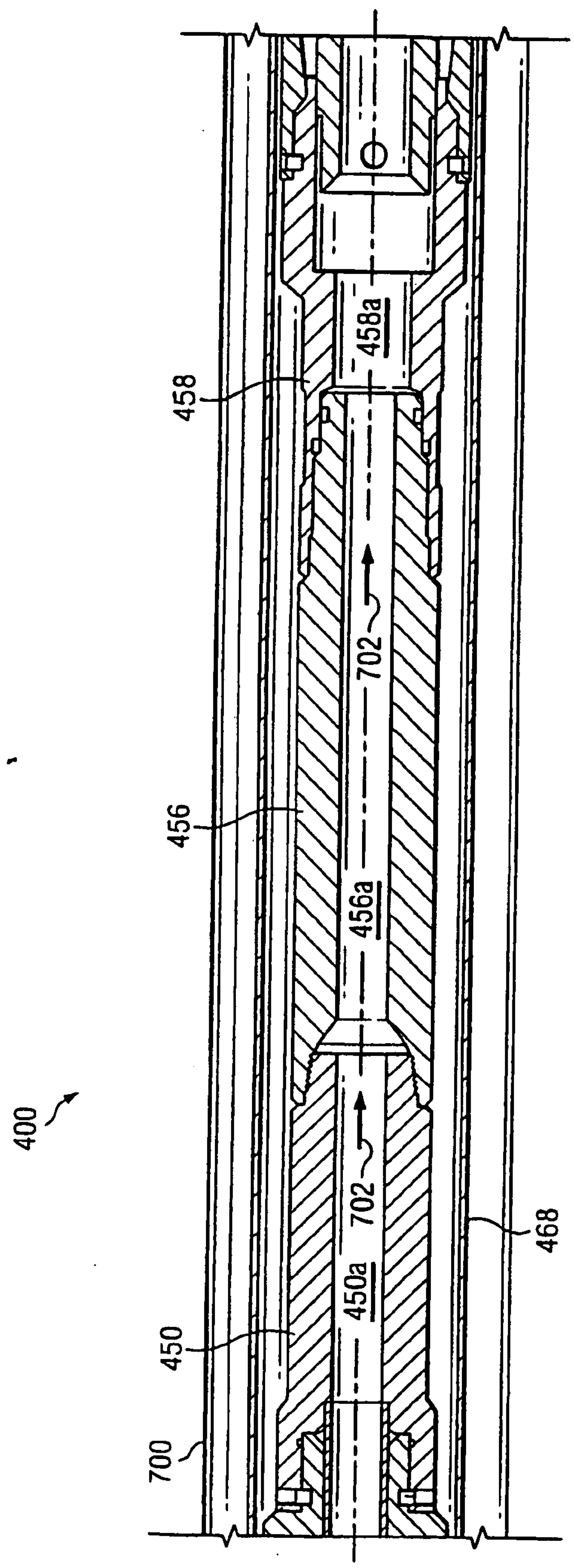
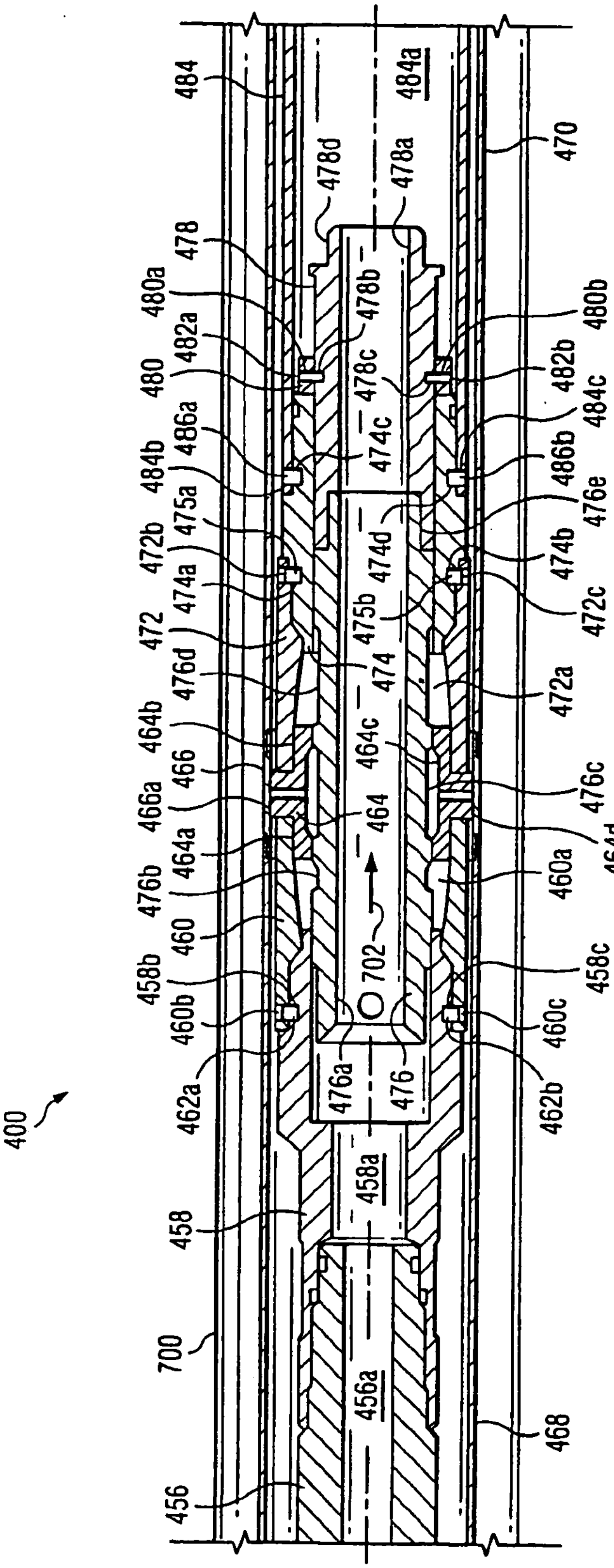


Fig. 26c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464
464a
464d
476b
460a
460
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460c
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476a
476
462b
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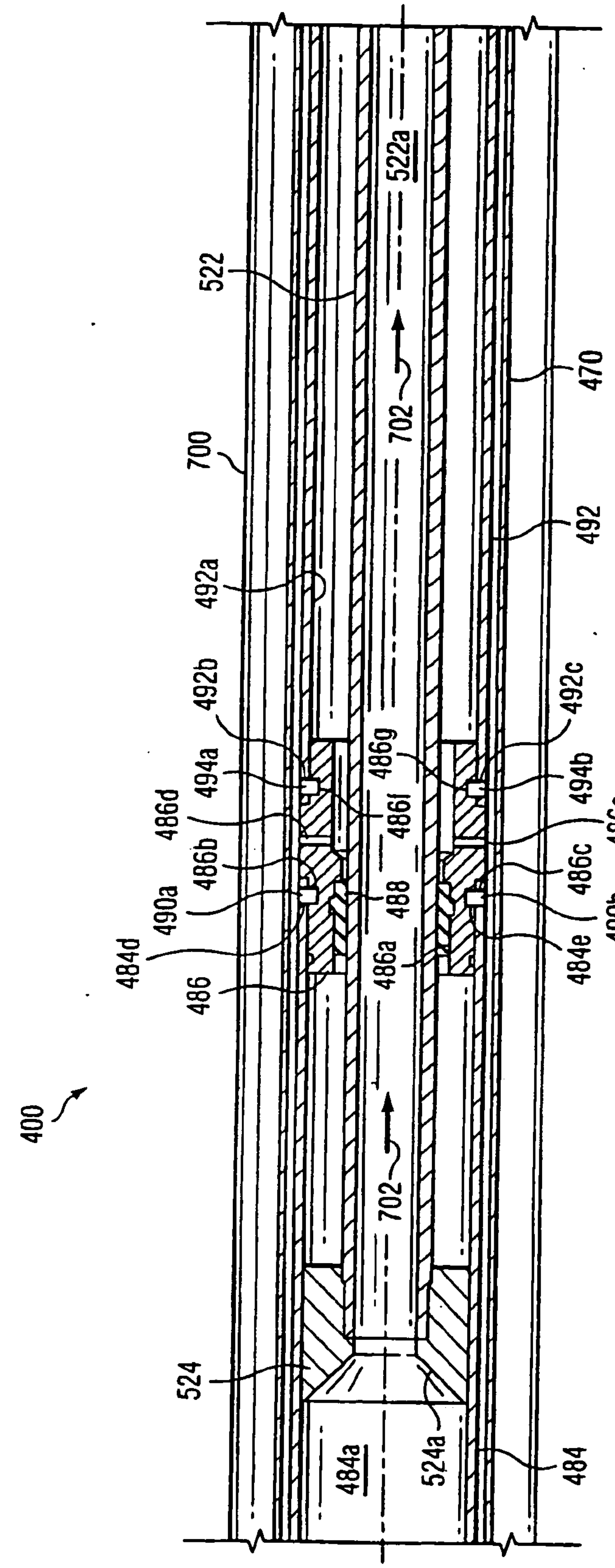
458a
458
700
456a
468
456

Fig. 26d



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494b
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486g
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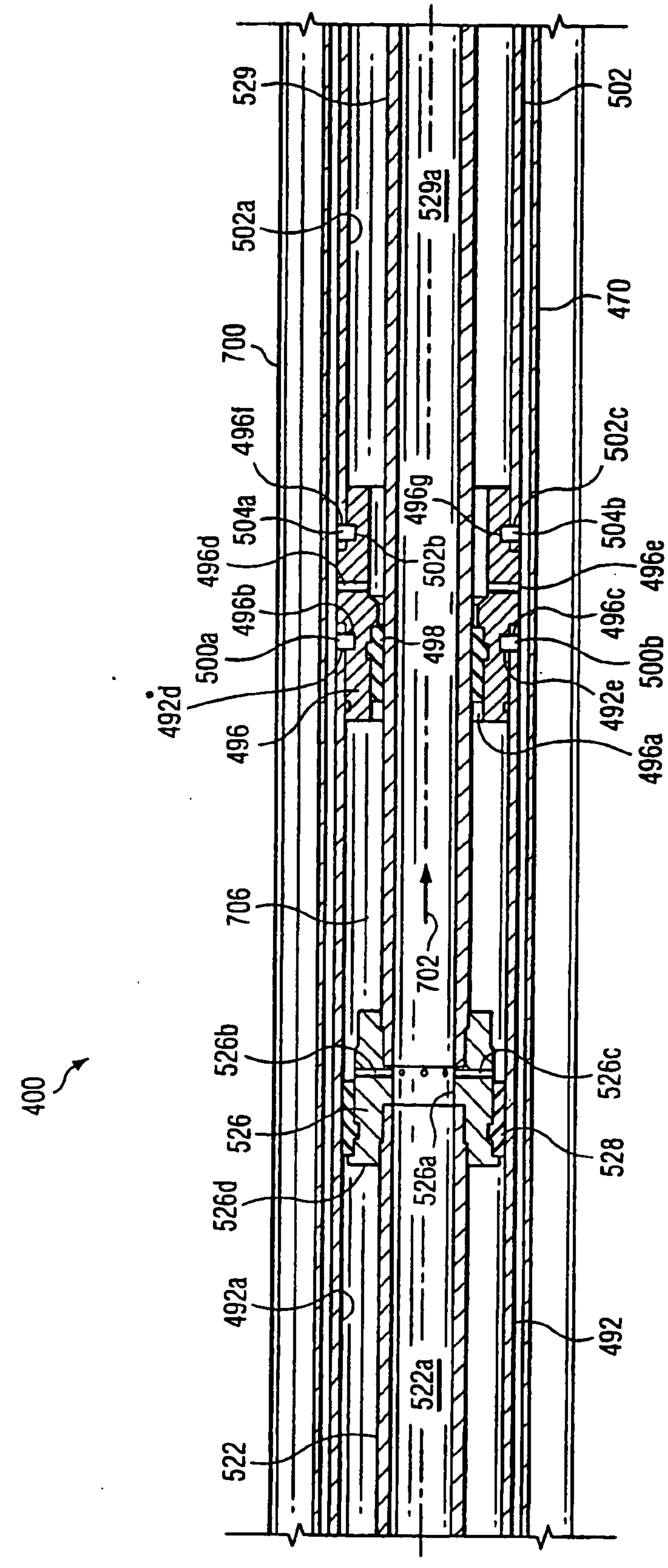
488
490b
484d
486a
484e
486
524
524a
484a
484

Fig. 26e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529a
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496e
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500a
498
500b
492d
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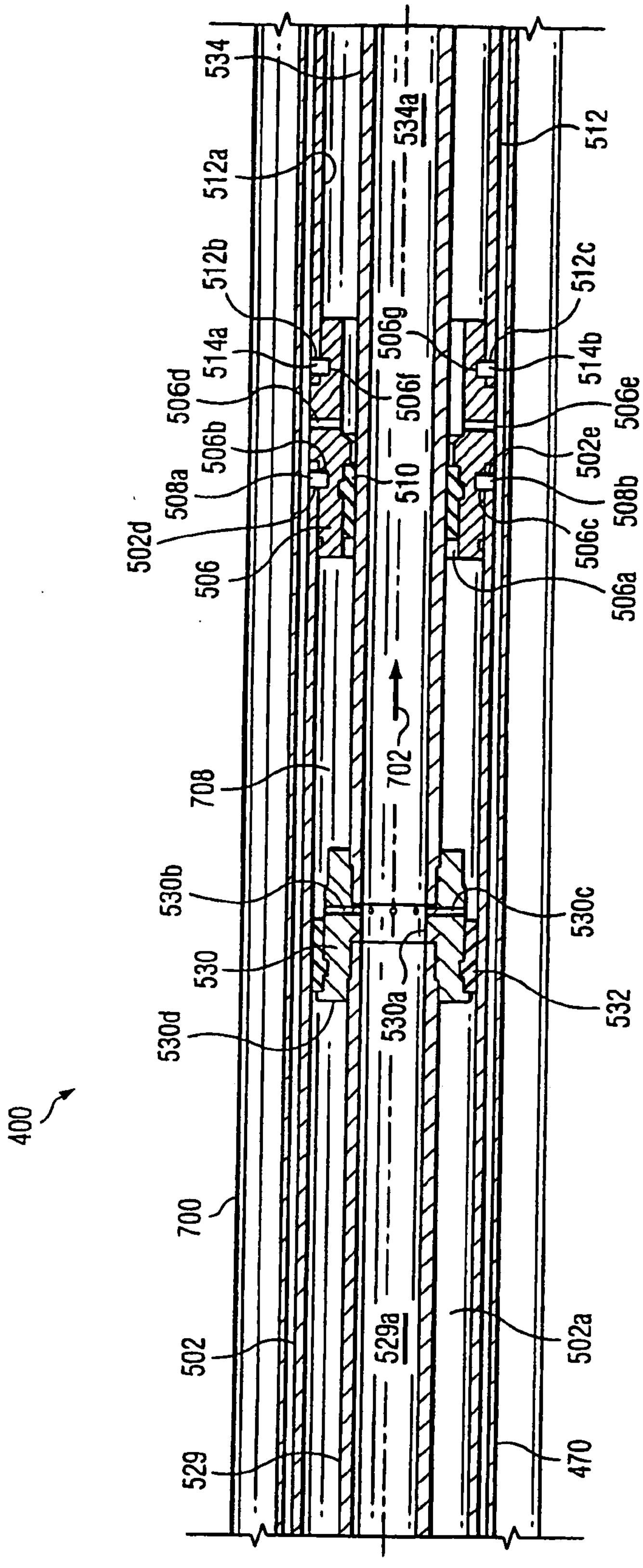
528
526d
526a
492a
492
522
522a

Fig. 26f



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506d
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506b
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508b
502d
506c
506
506a
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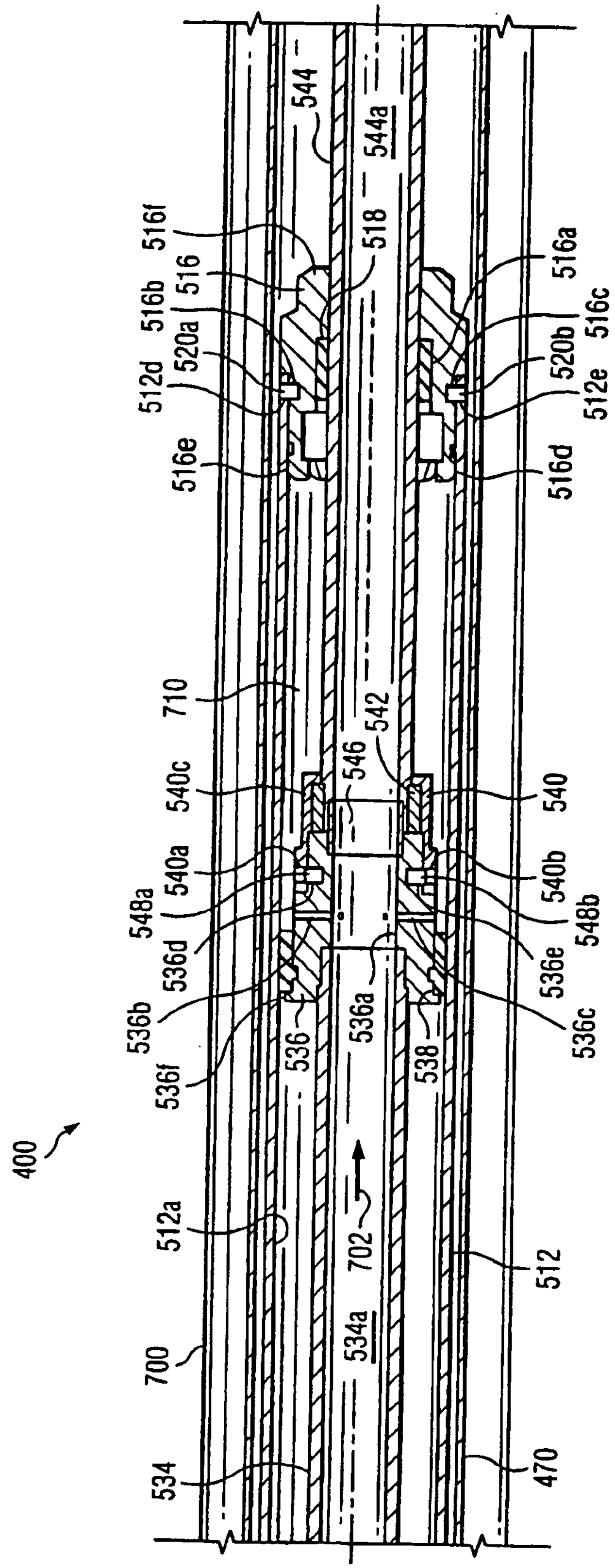
530c
530
530a
532
530d
400
700
502
529a
502a
529
470

Fig. 26g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520b
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516e
516d
710
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542
540
540a
548a
536d
536b
536f
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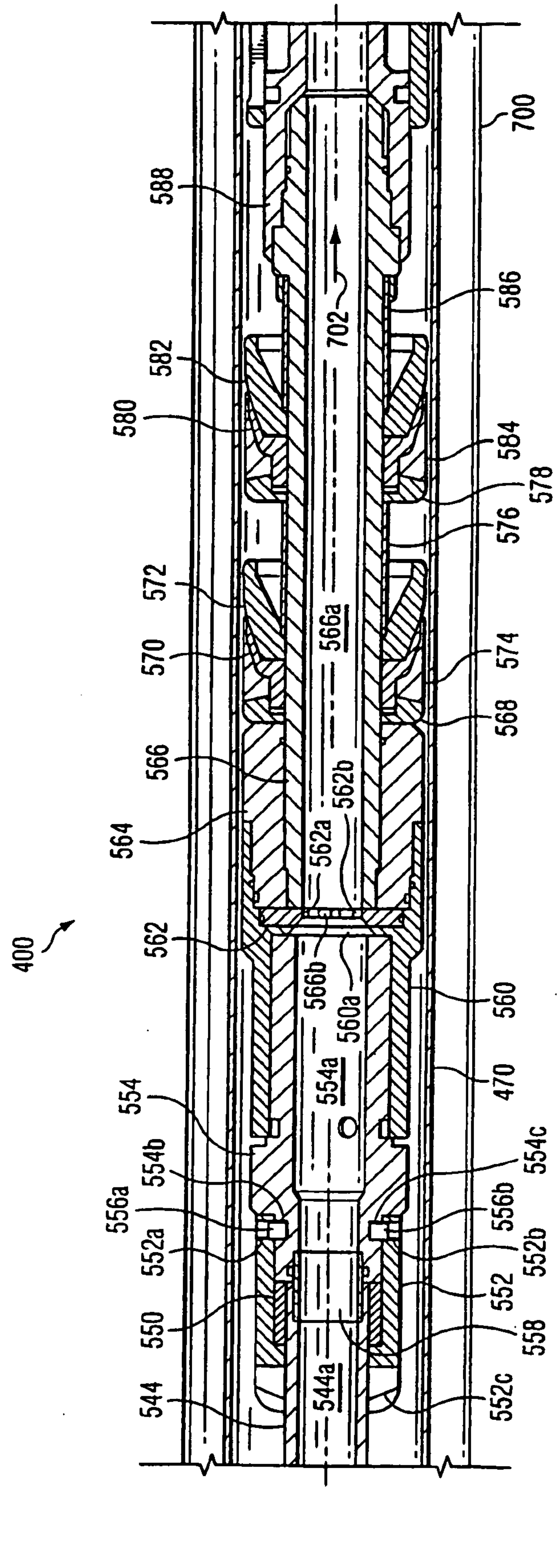
540b
548b
536e
536c
400
512a
702
534a
512
700
534
470

Fig. 26h



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562
554
554b
556a
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550
544
700
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578
576
566a
574
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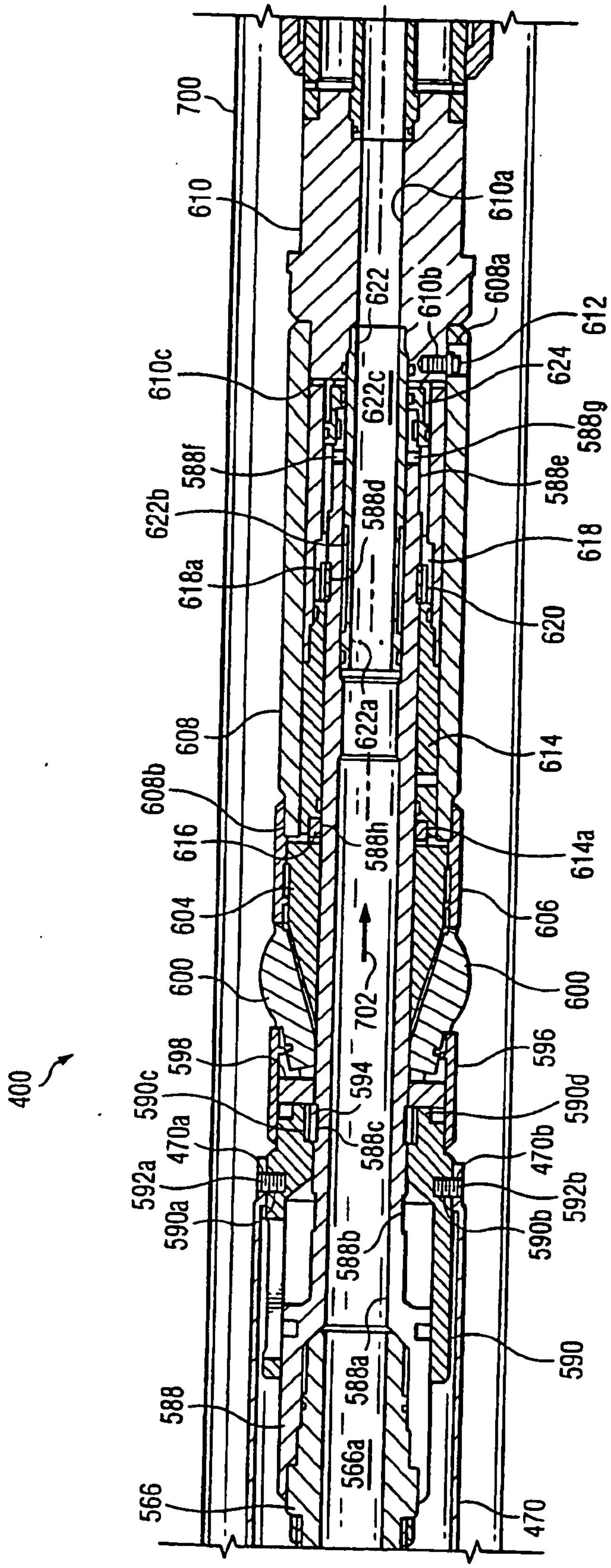
556b
552b
552
558
544a
552c

Fig. 26i



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700
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588d
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620
622a
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614
608b
588h
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600
702
598
596
594
590c
590d
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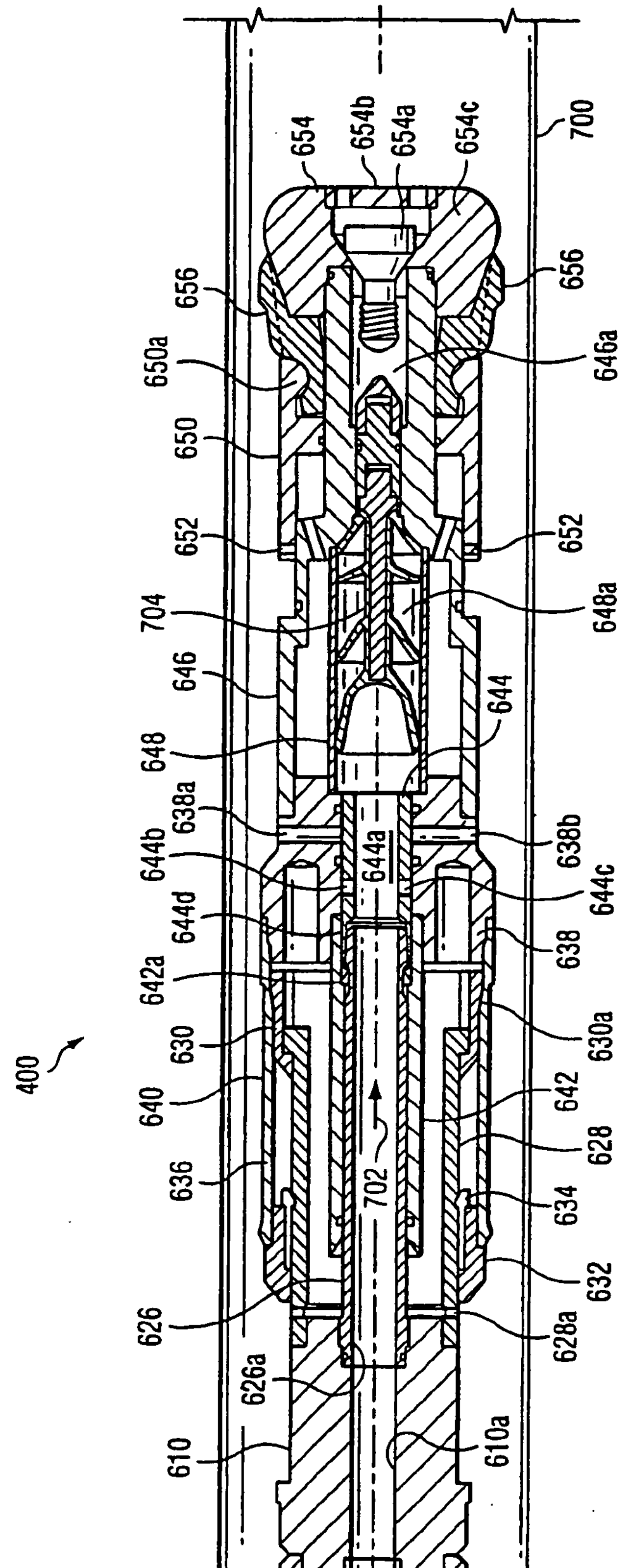
588
588a
566a
566
470

Fig. 26j



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704
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638a
644b
644a
638b
644c
644d
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634
632
626
628a
626a
610
610a

Fig. 26k

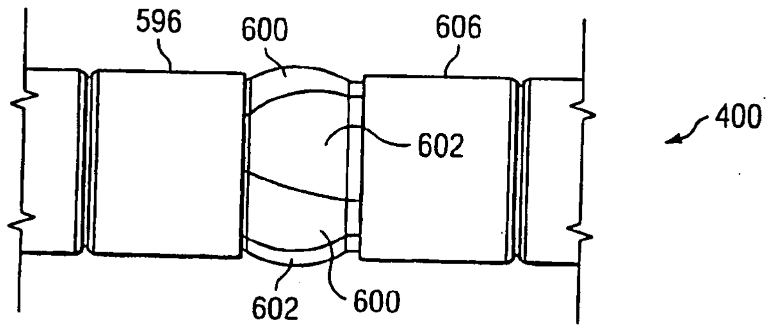


Fig. 27a

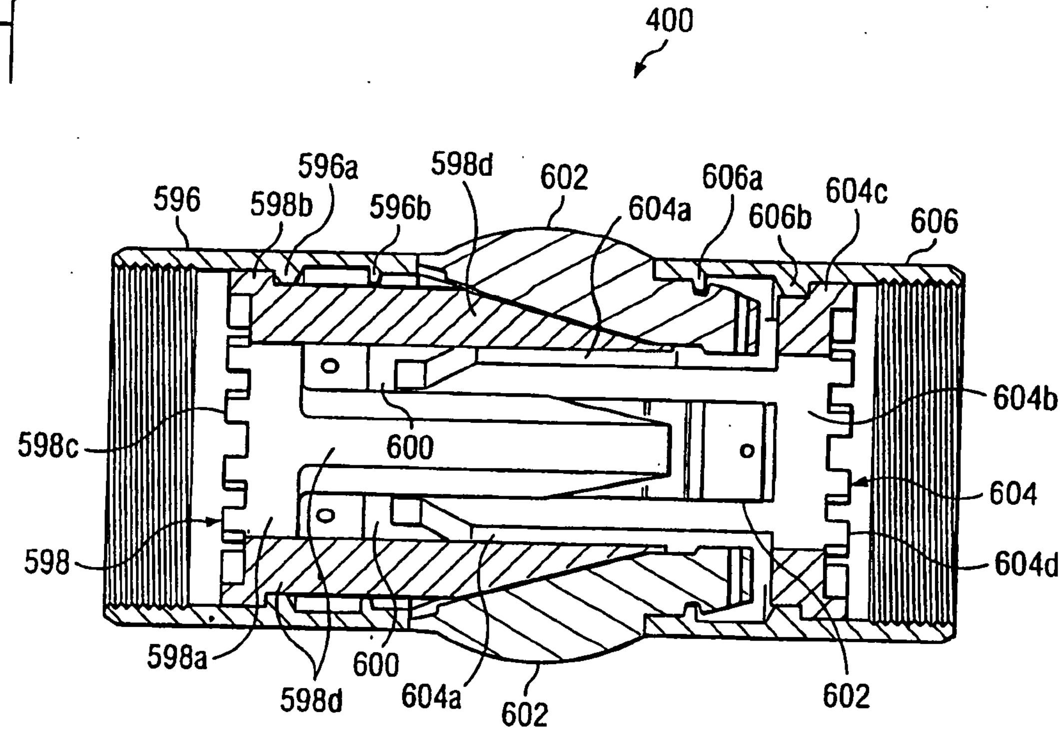
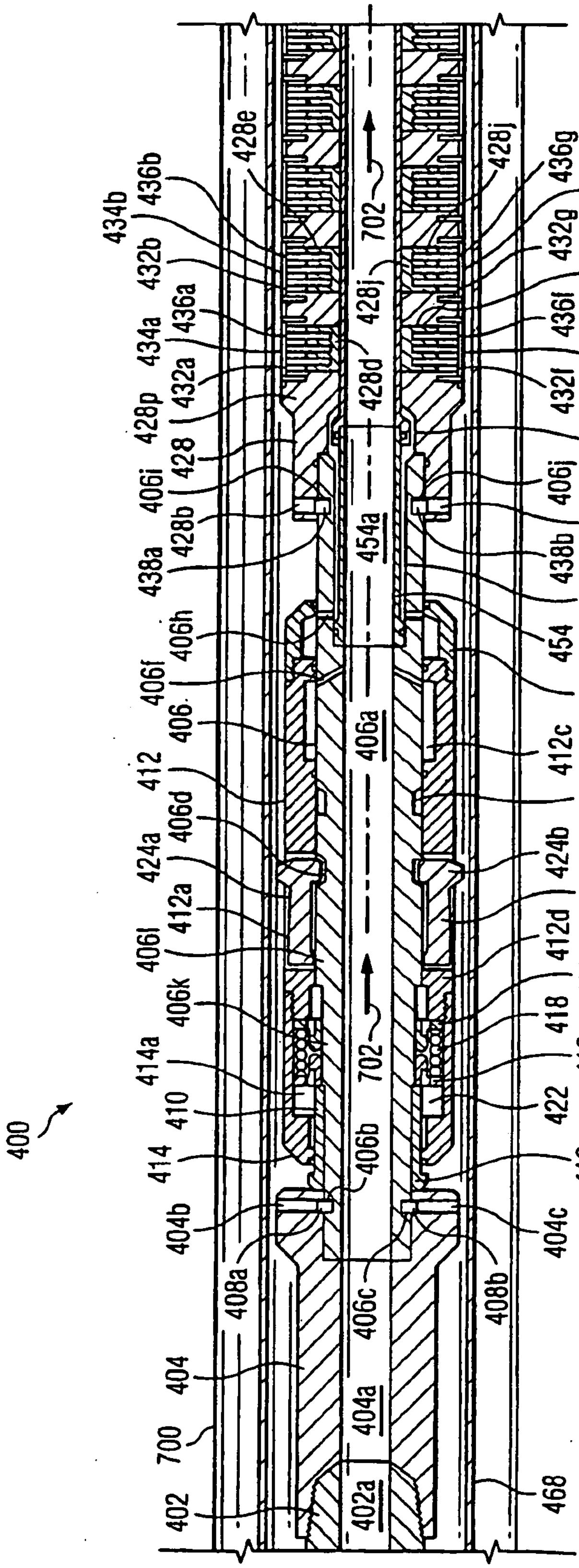


Fig. 27b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428j
428p
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432f
432g
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436f
436g
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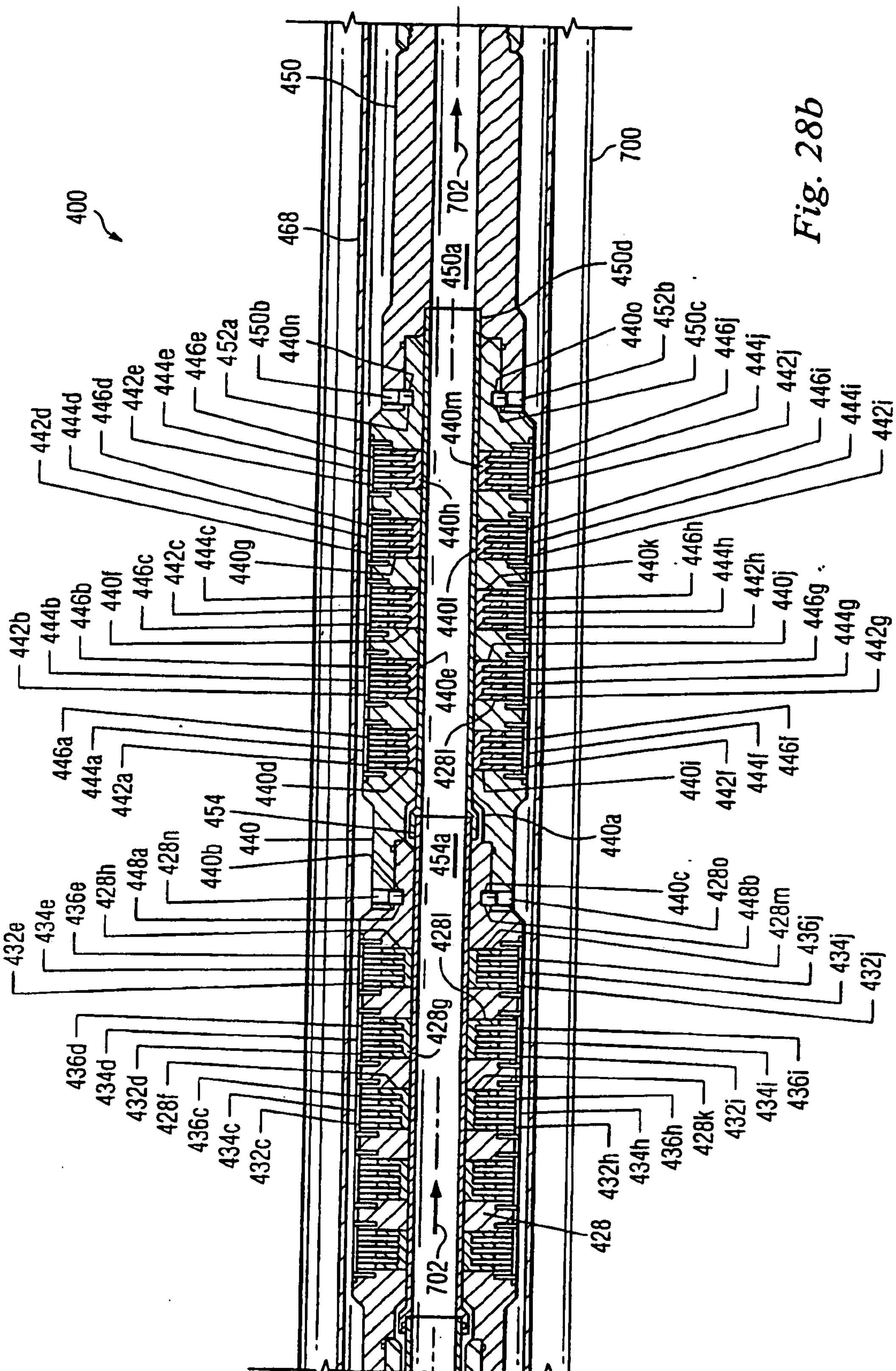
438b
454
454a
468
700
702

Fig. 28a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442h
440j
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436j
434j
432j
436i
434i
432i
428k
436h
434h
432h
428
452a
450b
440n
446e
444e
442e
446d
444d
442d
440m
440h
440g
444c
442c
446c
440f
446b
444b
442b
440l
440e
428l
446a
444a
442a
440d
454
440
440b
454a
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434e
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428g
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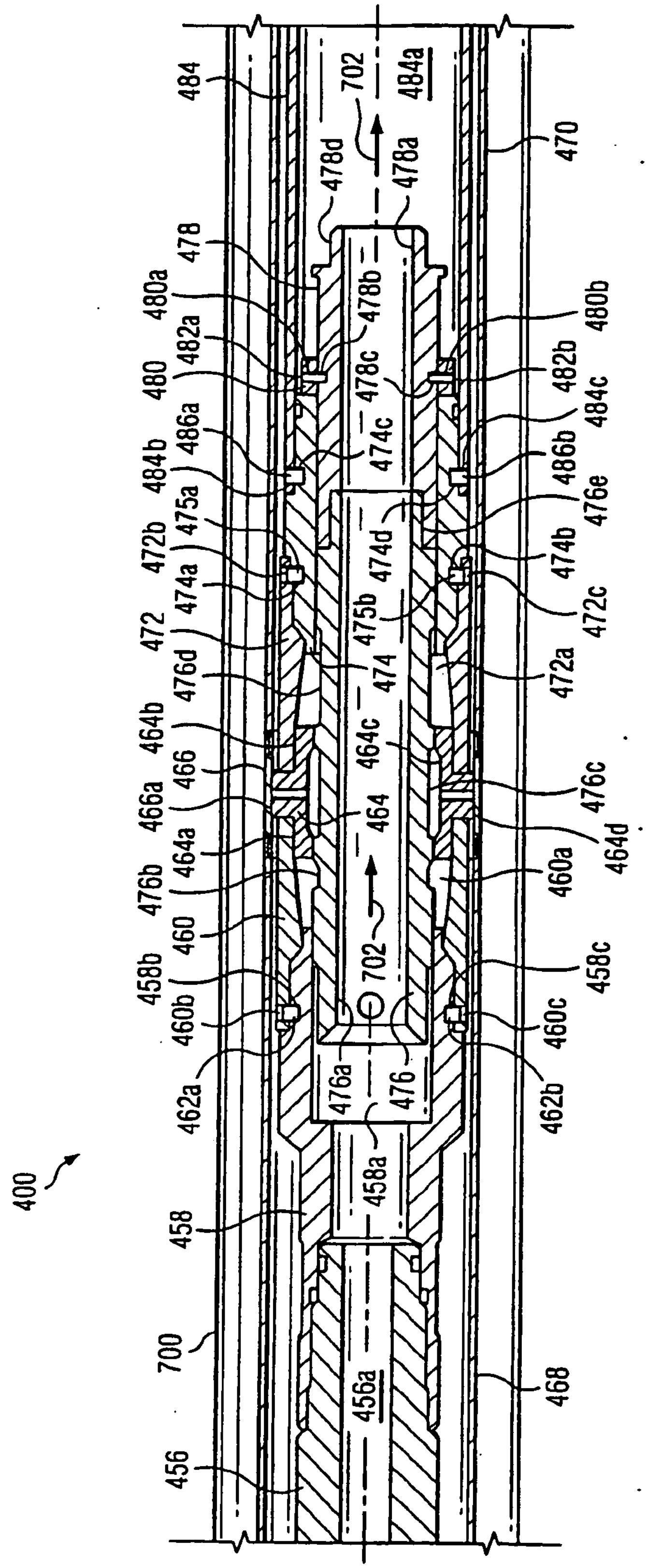
434d
432d
428f
436c
434c
432c

Fig. 28b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474c
474d
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475b
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476a
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476c
476d
476e
478
478a
478b
478c
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480b
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482b
484
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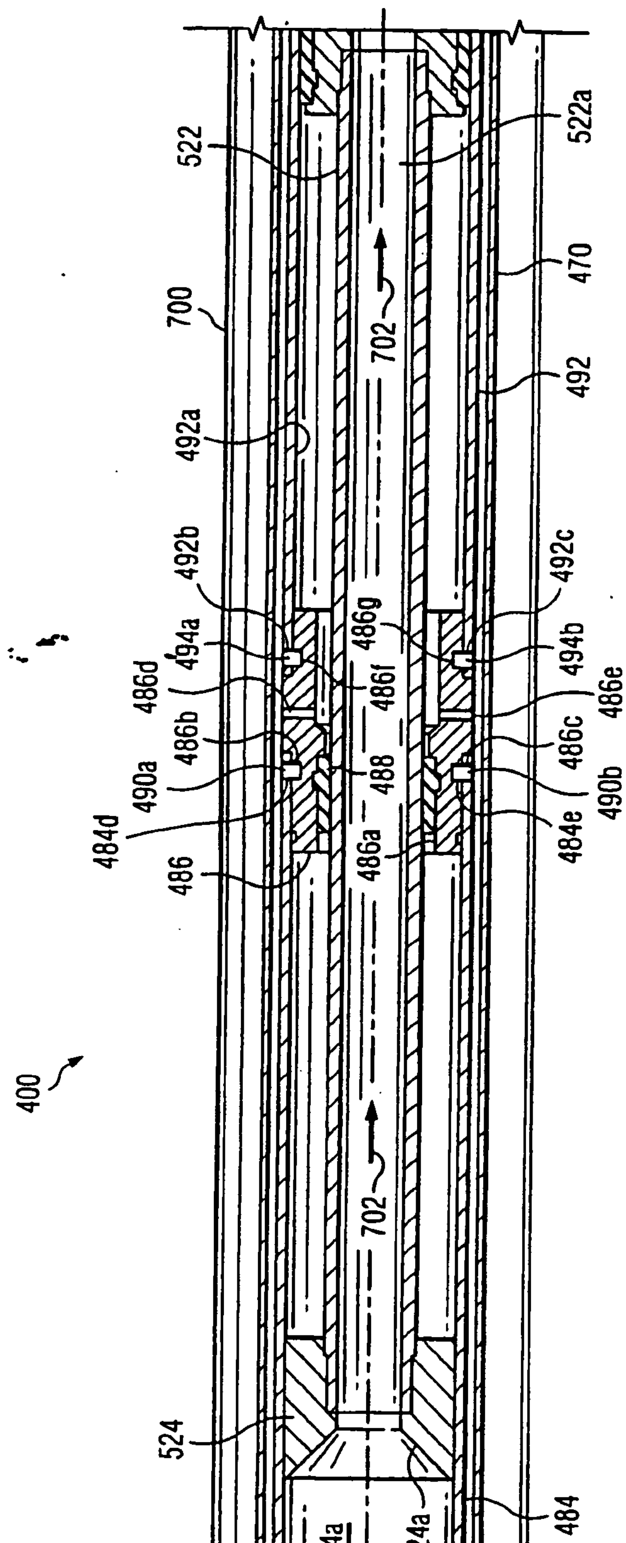
484b
484c
486a
486b
700
702

Fig. 28c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486f
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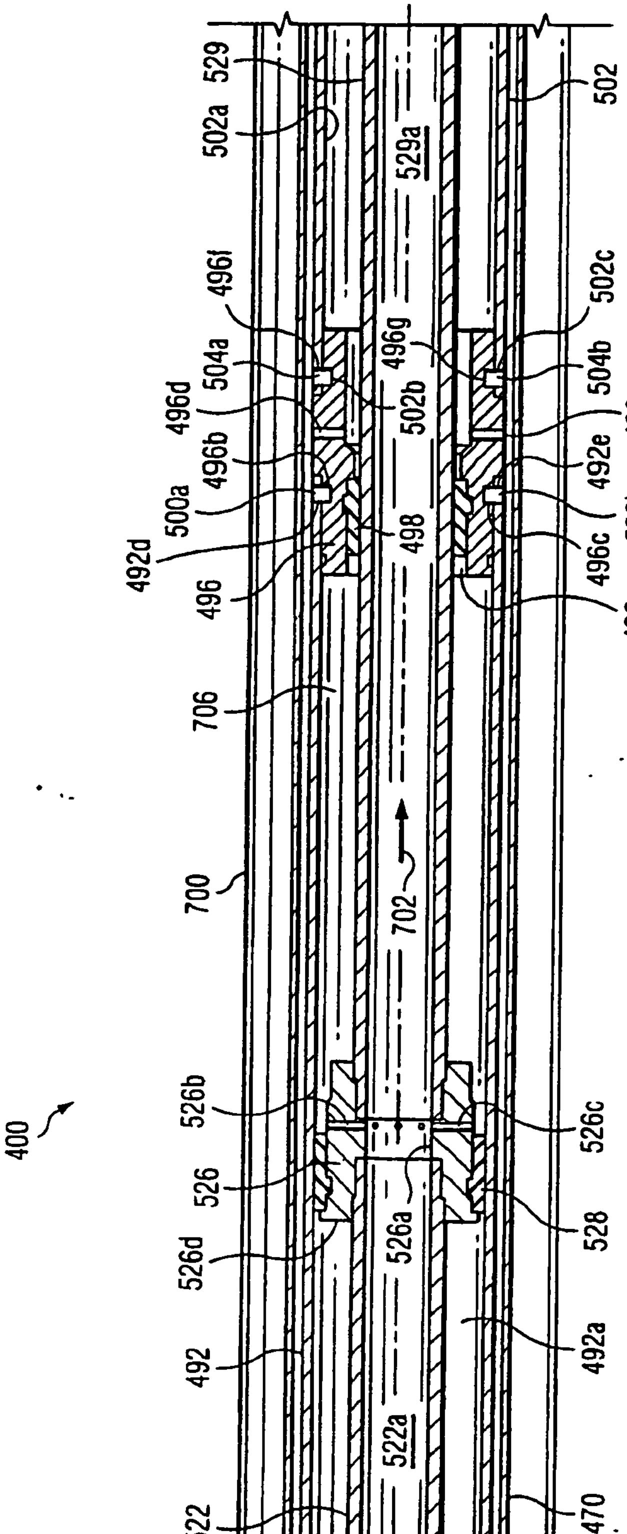
490b
484d
484e
486a
486
400
702
524
524a
484a
484

Fig. 28d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496e
492e
500b
498
496c
496a
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702
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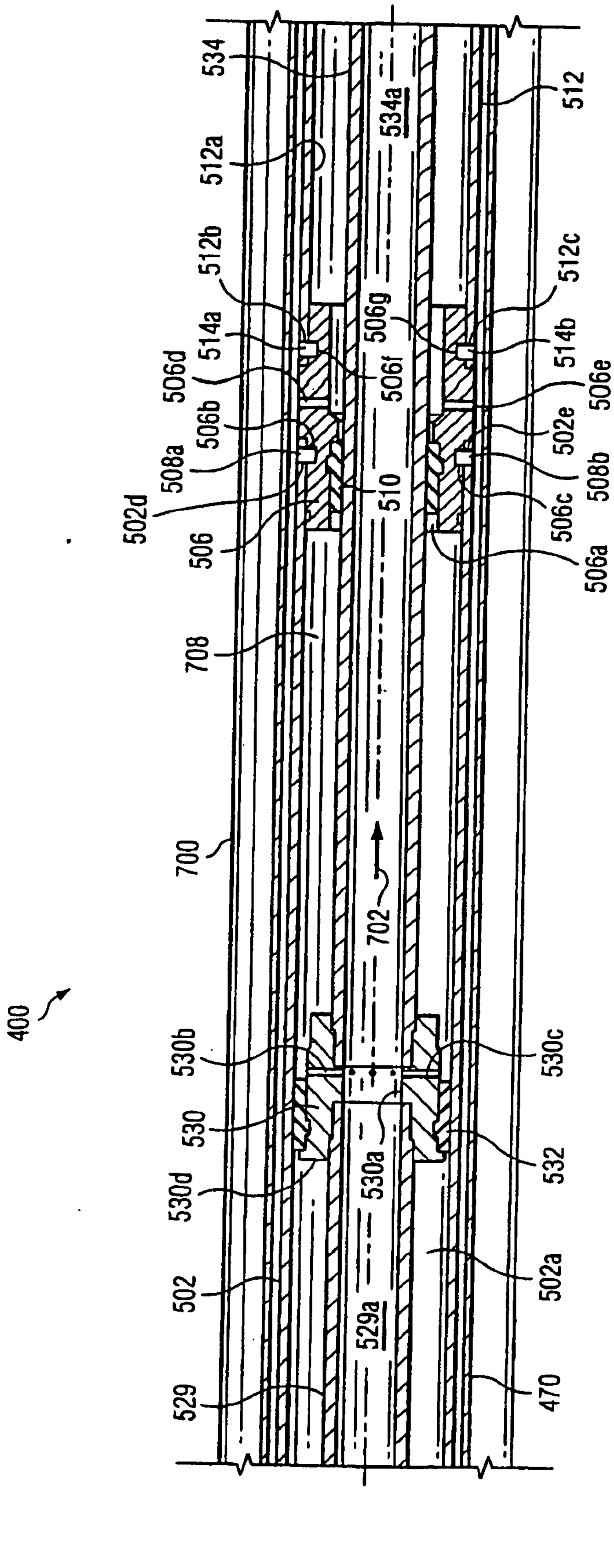
526d
526a
526c
528
492
492a
522
522a
470

Fig. 28e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502d
510
506c
506
506a
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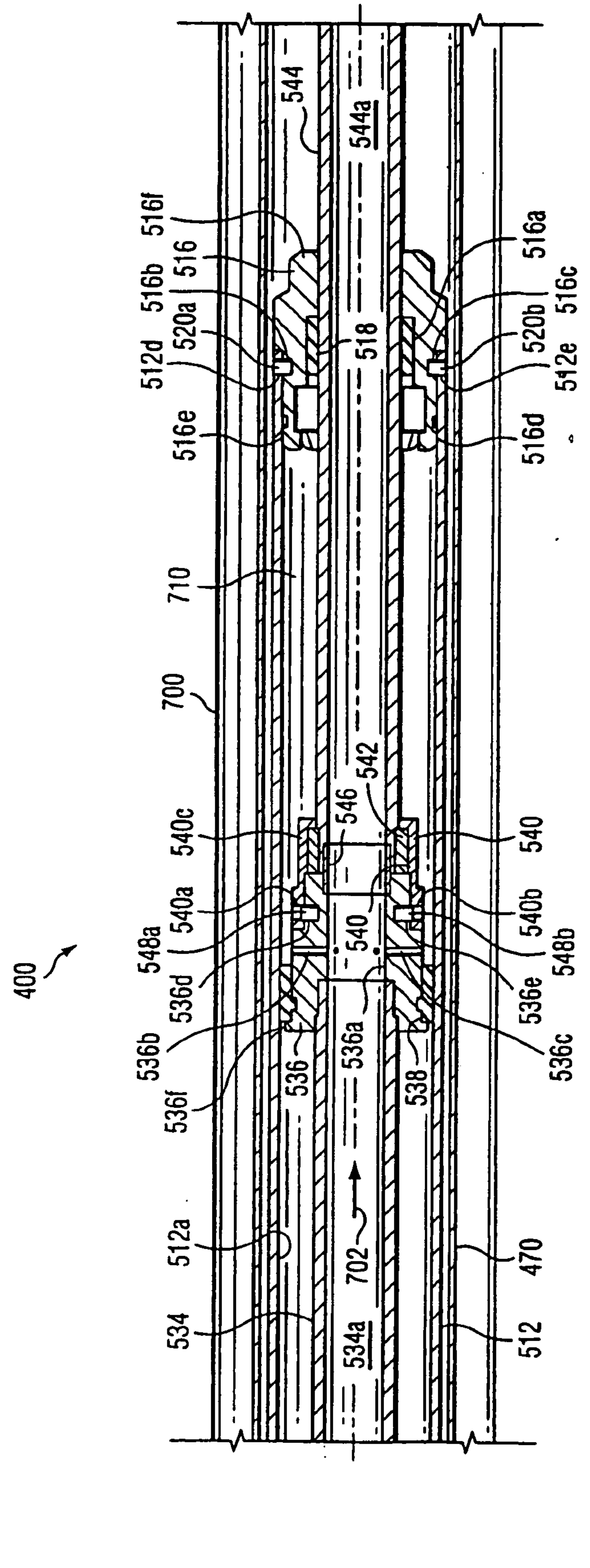
400
530b
530c
530
530a
532
530d
502
502a
529
529a
470

Fig. 28f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700
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546
542
540
540a
548a
536d
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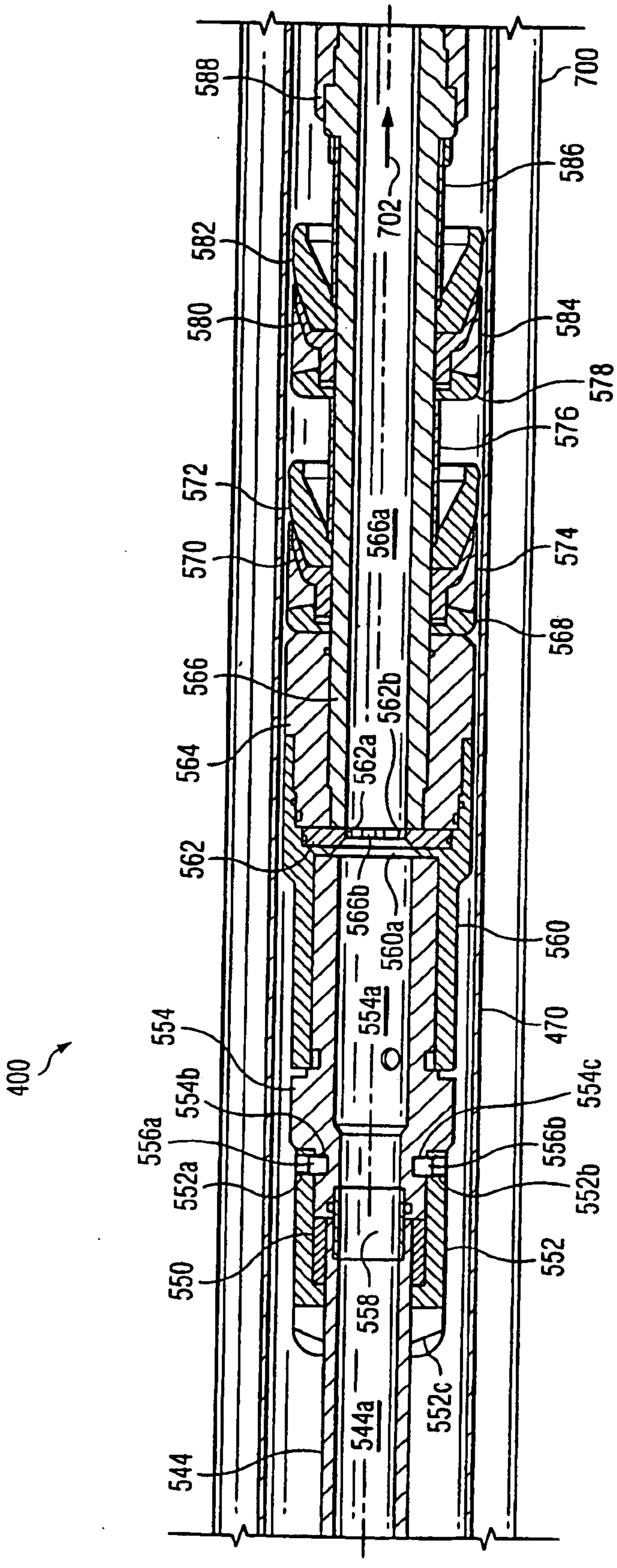
540
538
540b
548b
536e
536c
512a
702
534
534a
470
512

Fig. 28g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562a
562b
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560a
554a
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470
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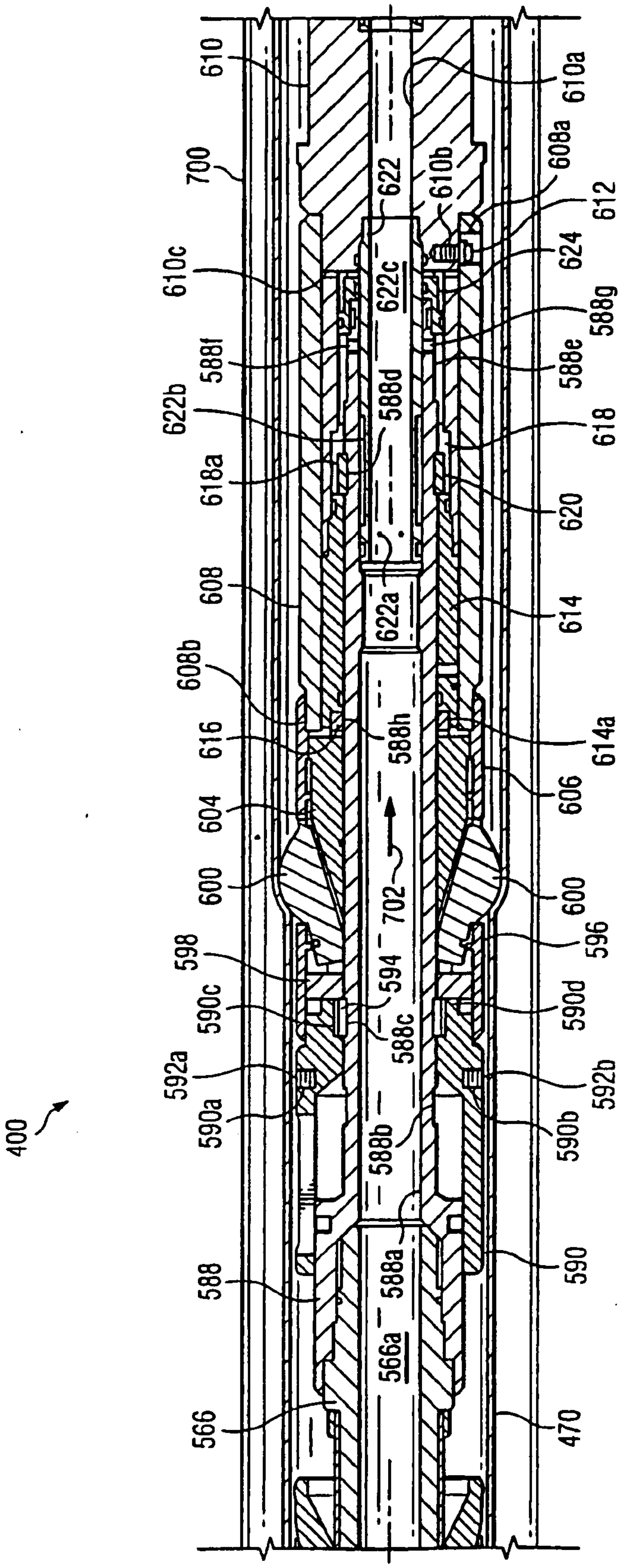
552b
552

Fig. 28h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604
600
702
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594
596
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588b
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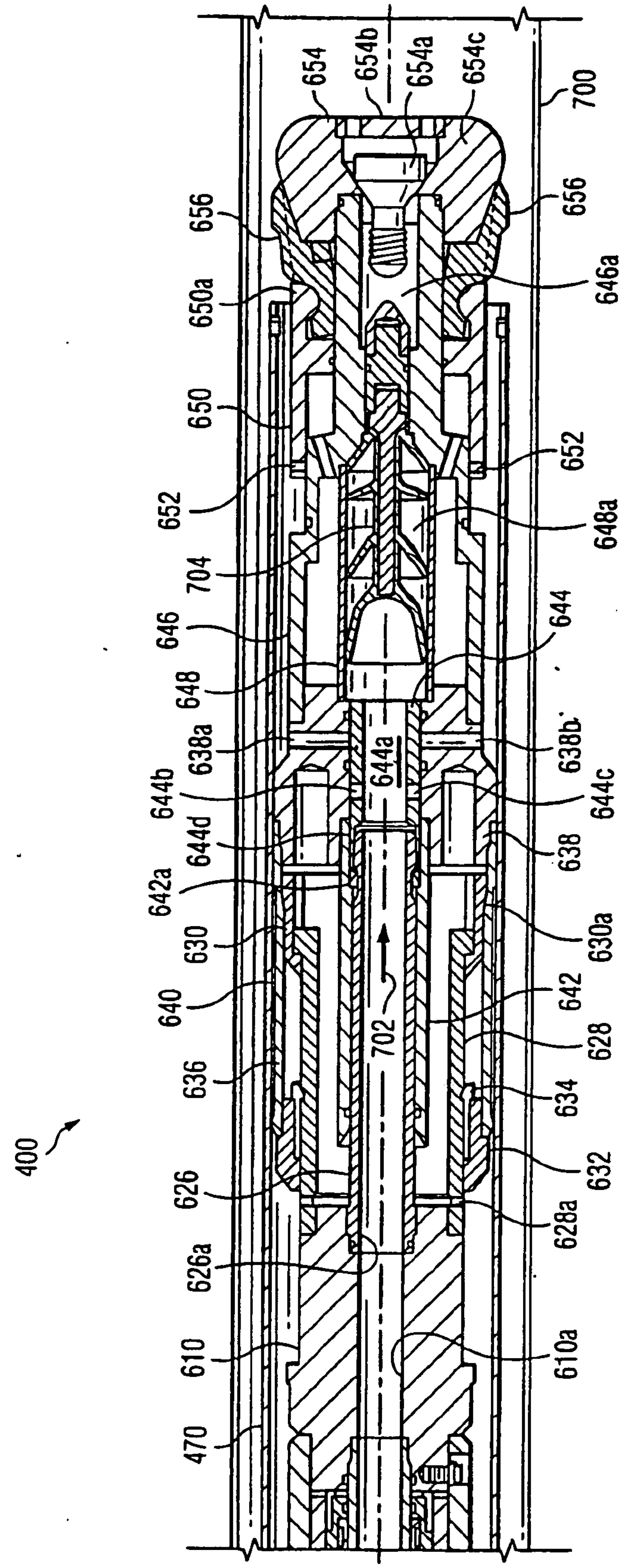
566
470

Fig. 28i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644b
644c
644d
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636
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628a
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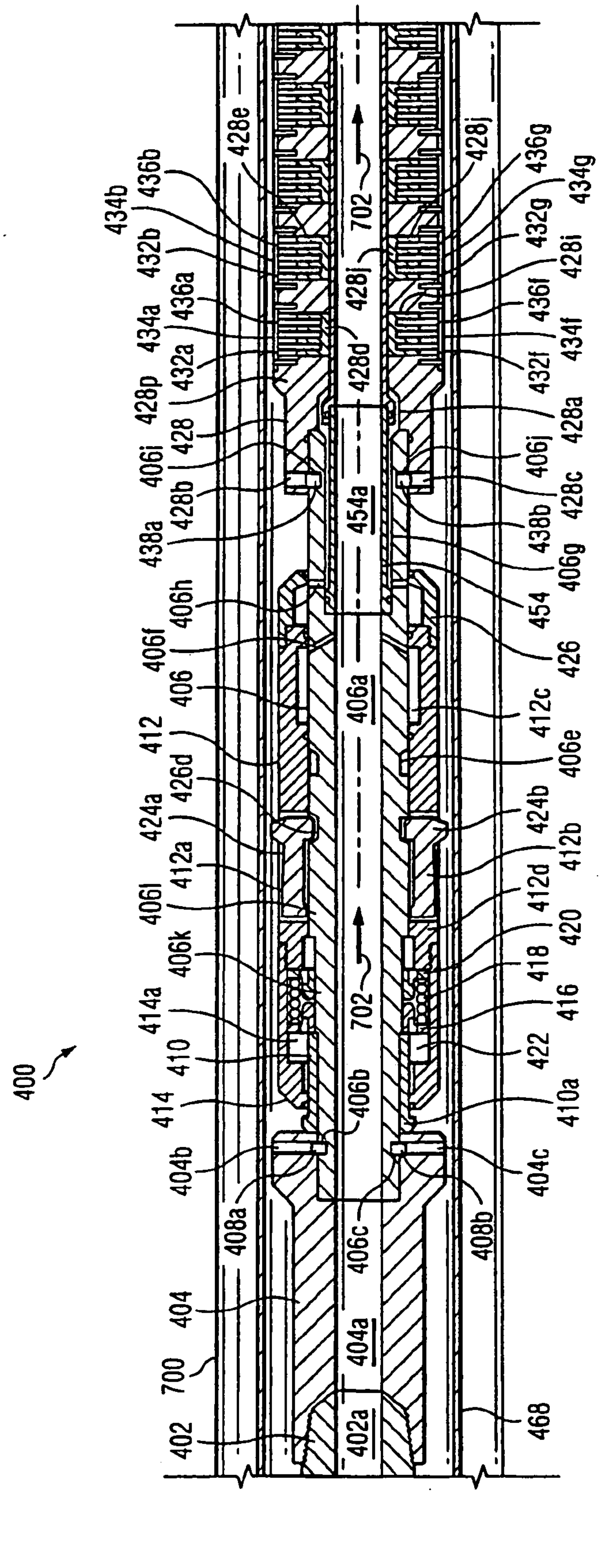
610
610a
470

Fig. 28j



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426d
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428b
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428d
428e
428i
428j
428p
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432b
432f
432g
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436f
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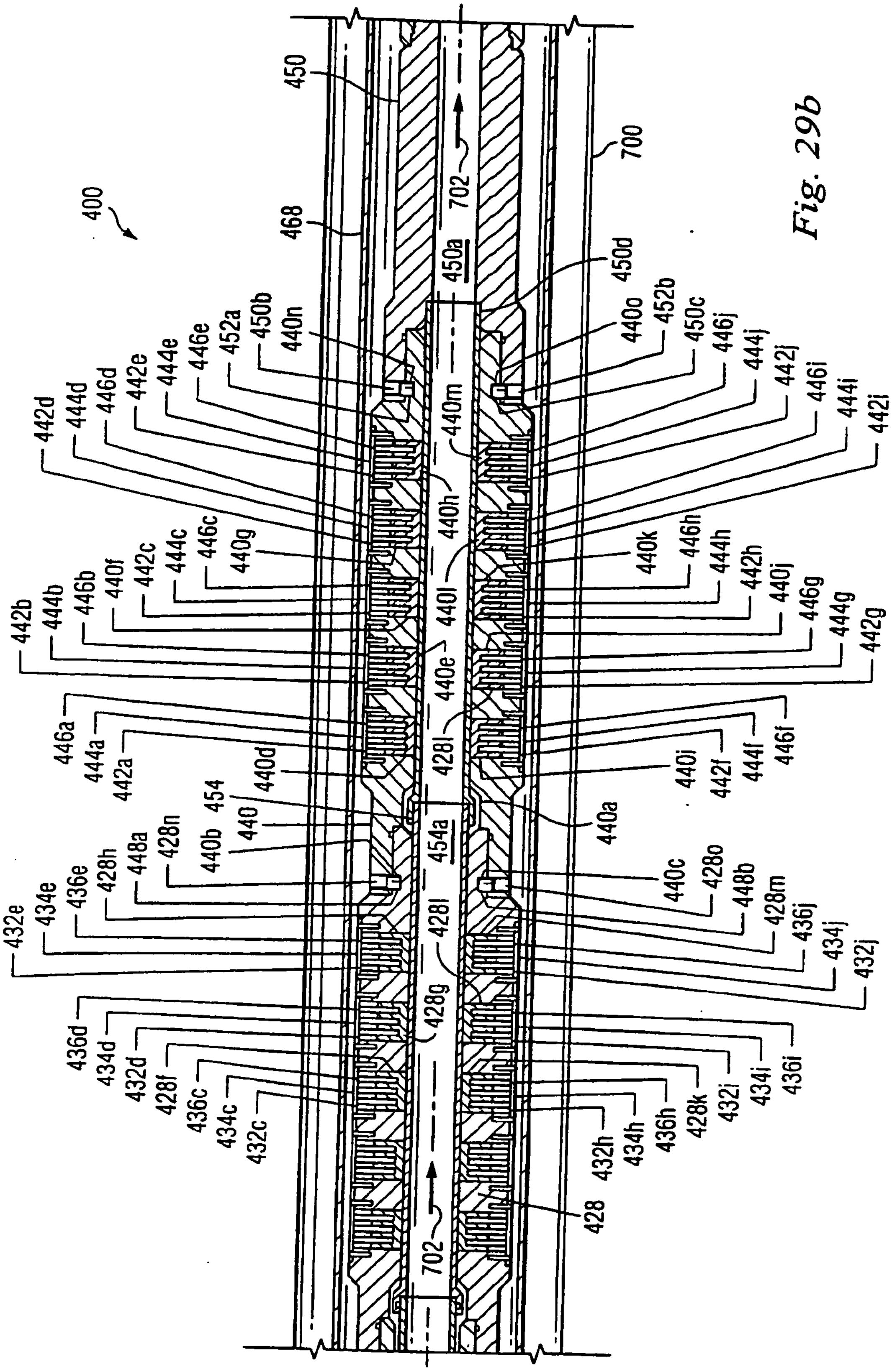
438a
438b
454
454a
468
700
702

Fig. 29a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428o
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432j
428g
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432h
428

Fig. 29b

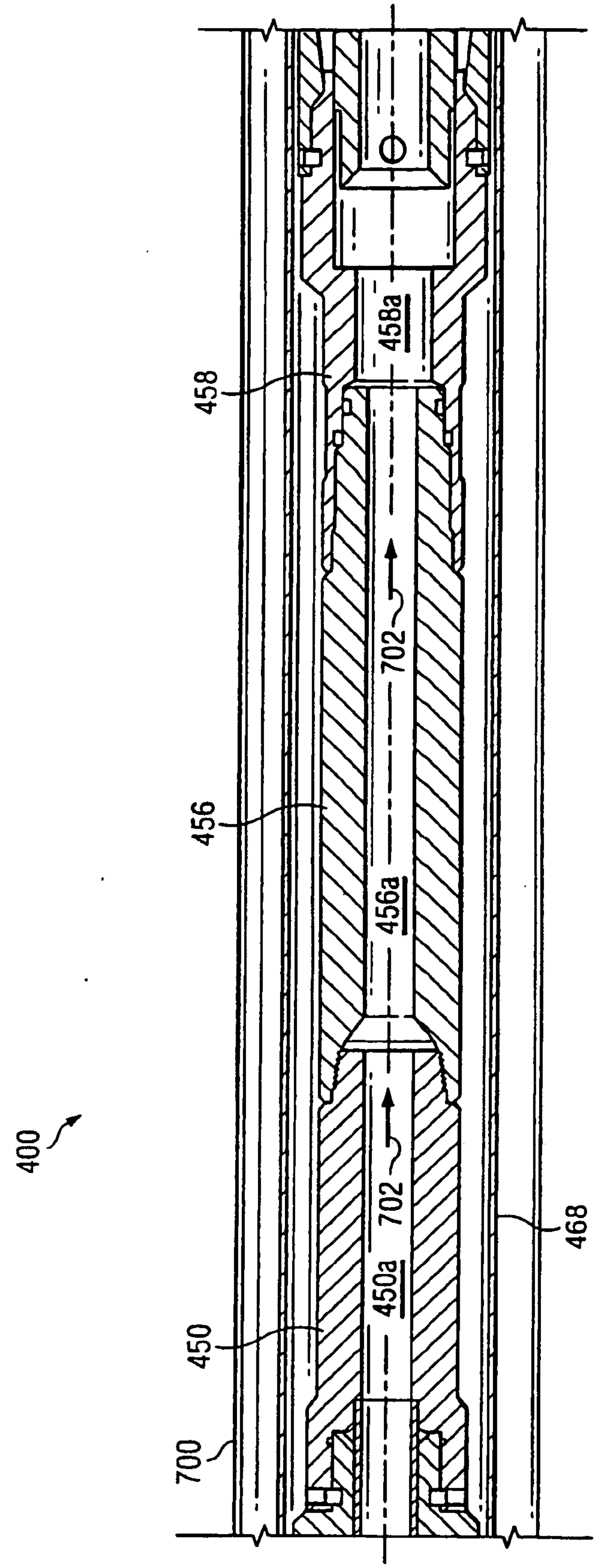
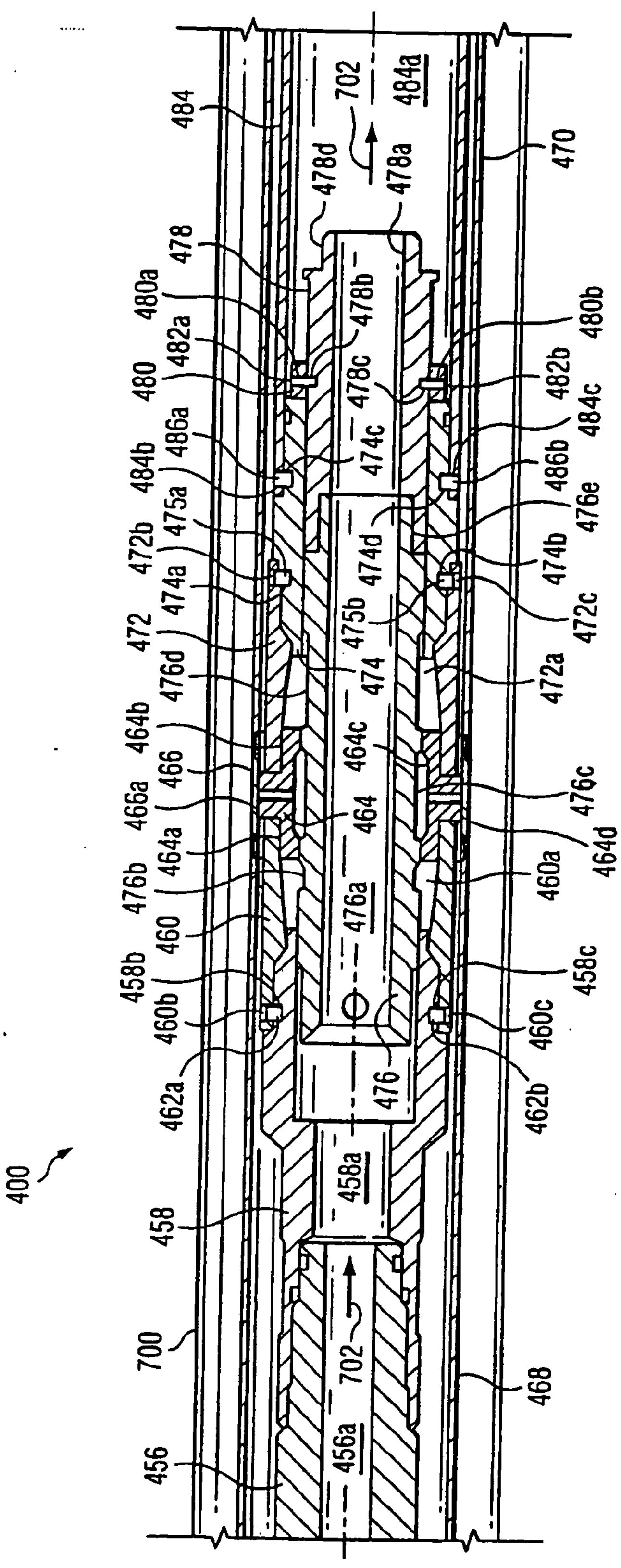


Fig. 29c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486b
476e
475a
472b
474d
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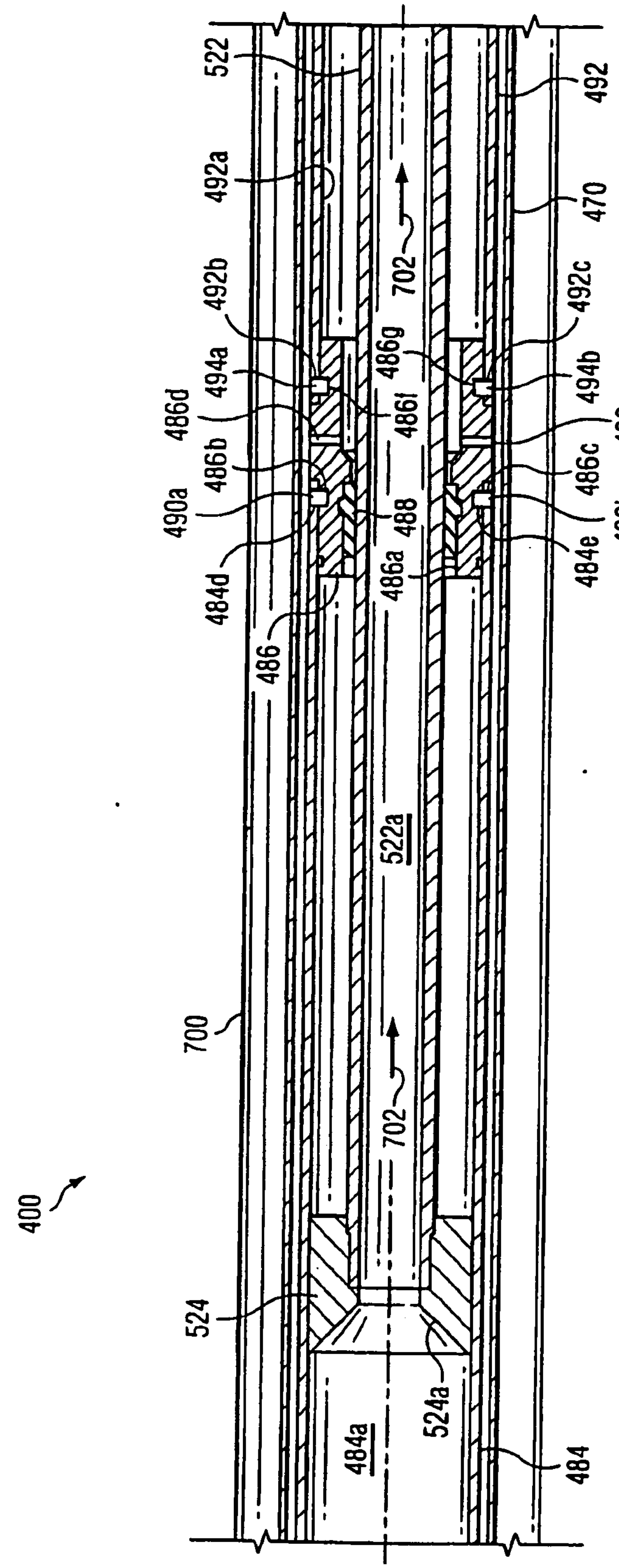
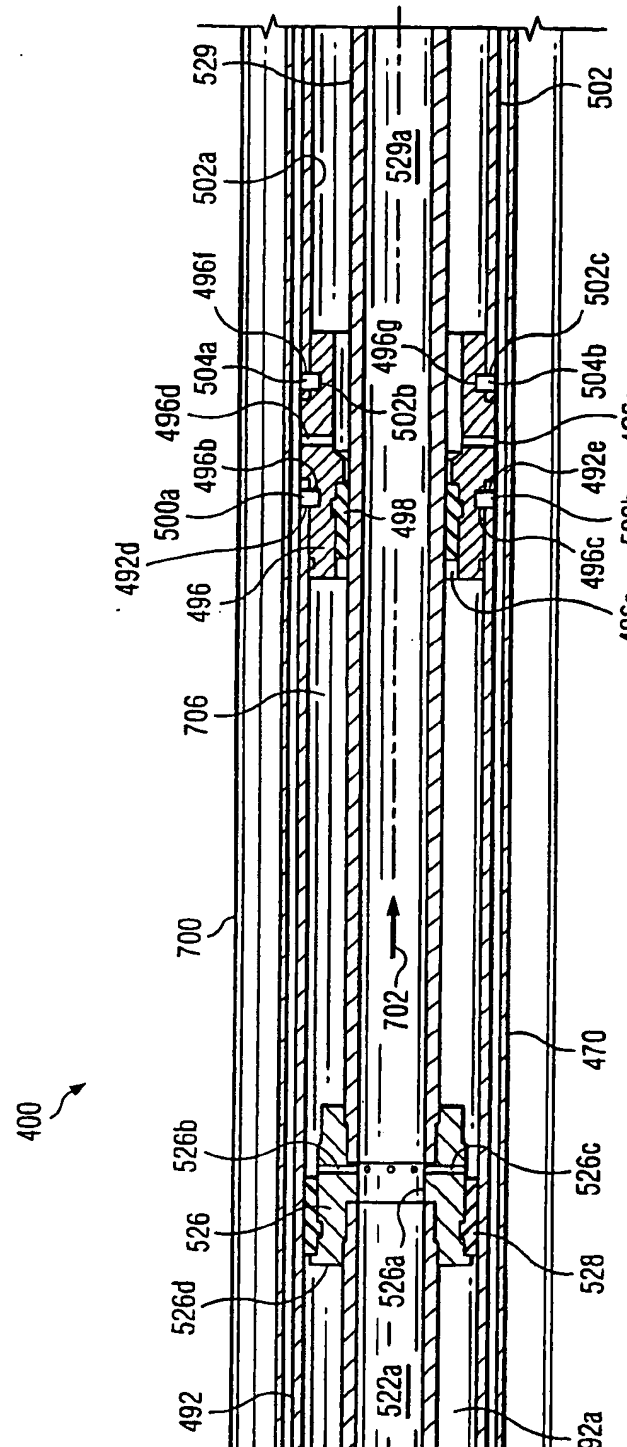
472c
472
475b
476d
474
472a
464b
464c
466
476c
466a
464
464d
464a
460a
476b
476a
460
458b
458c
460b
460c
476
462a
462b
458a
458
700
702
468
456
456a

Fig. 29d



522
492
492a
470
702
492b
492c
494a
486g
494b
486d
486f
486e
486b
486c
490a
488
490b
484d
486a
484e
486
522a
700
702
400
524
524a
484a
484

Fig. 29e



529
502a
496f
504a
496d
496b
500a
492d
496
706
700
400
526b
526
526d
492
522
529a
496g
502b
498
702
526a
522a
502
502c
504b
496e
492e
500b
496c
496a
470
526c
528
492a

Fig. 29f

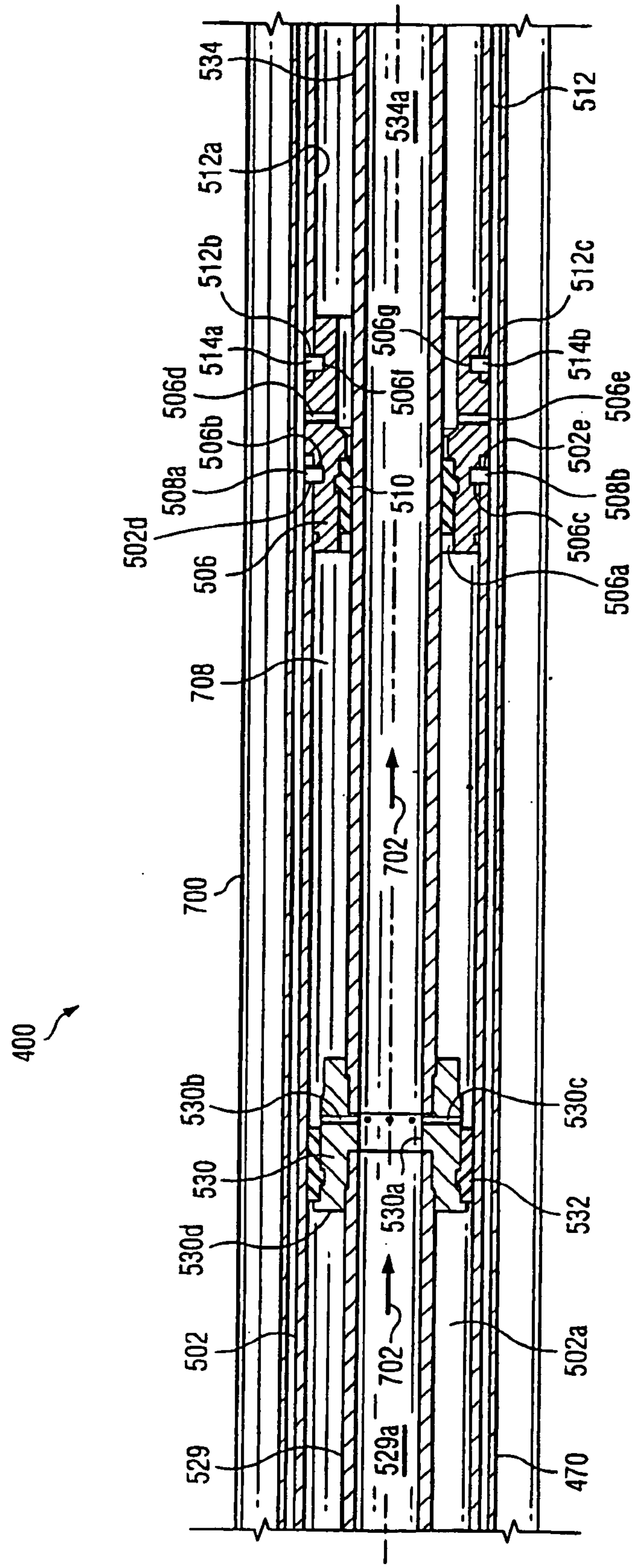

400
534
534a
512
512a
512b
512c
514a
514b
506g
506f
506d
506b
506e
502e
508a
508b
510
502d
506c
506
506a
708
702
700
530b
530c
530
530a
532
530d
502
502a
529
529a
470

Fig. 29g

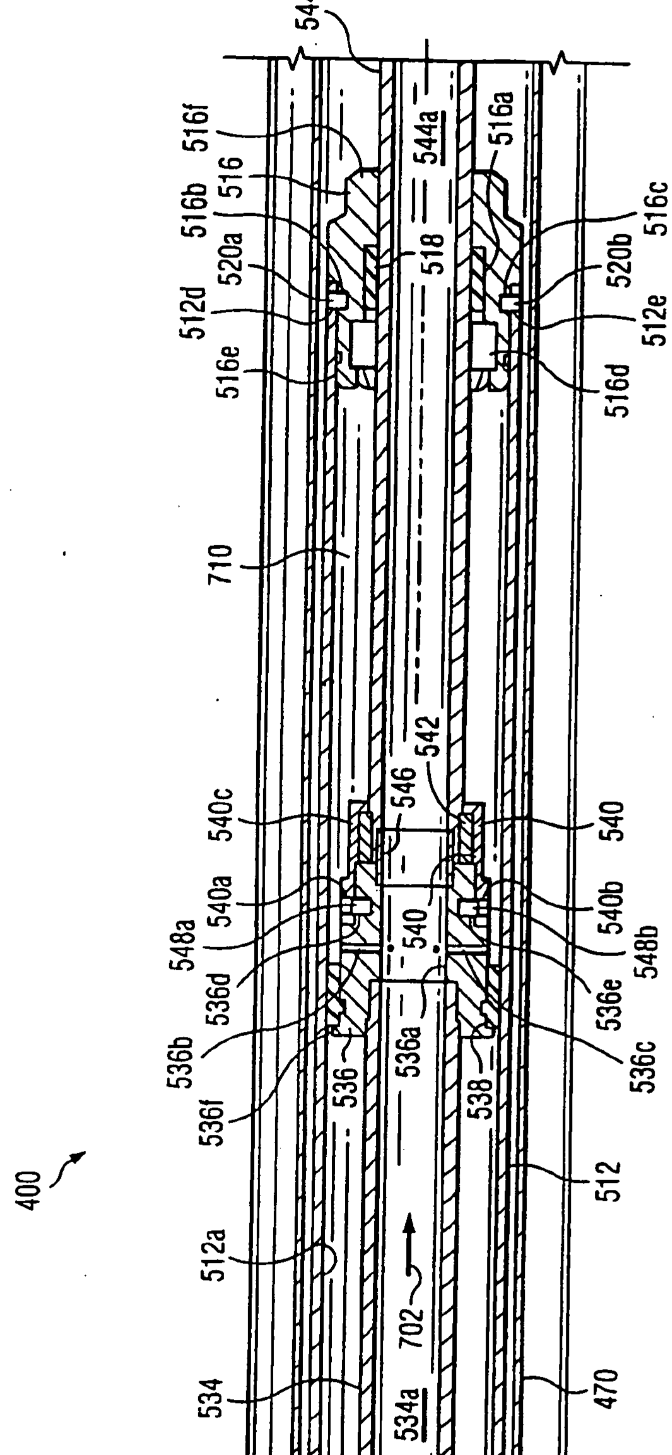
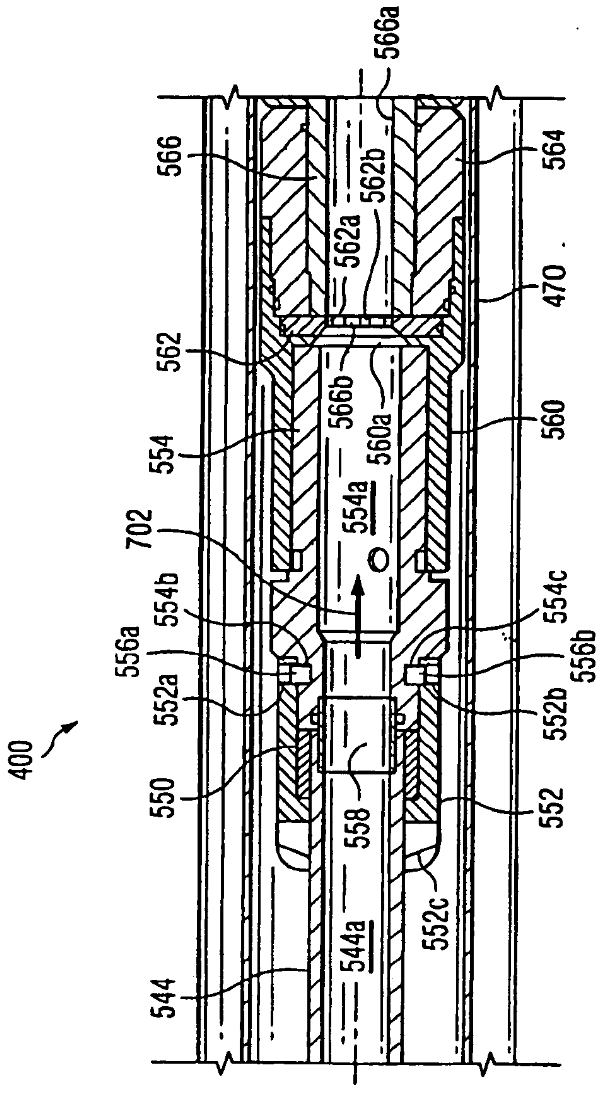

544
544a
516f
516
516a
516b
516c
520a
518
520b
512d
512e
516e
516d
710
542
546
540c
540
540a
540b
548a
548b
536d
536e
536b
536a
536c
536f
536
538
400
512a
512
702
534
534a
470
700

Fig. 29h



566a
566
564
562b
562a
470
562
566b
560a
560
554
554a
702
554b
554c
556a
556b
552a
552b
400
550
558
552
544a
552c
544

Fig. 29i

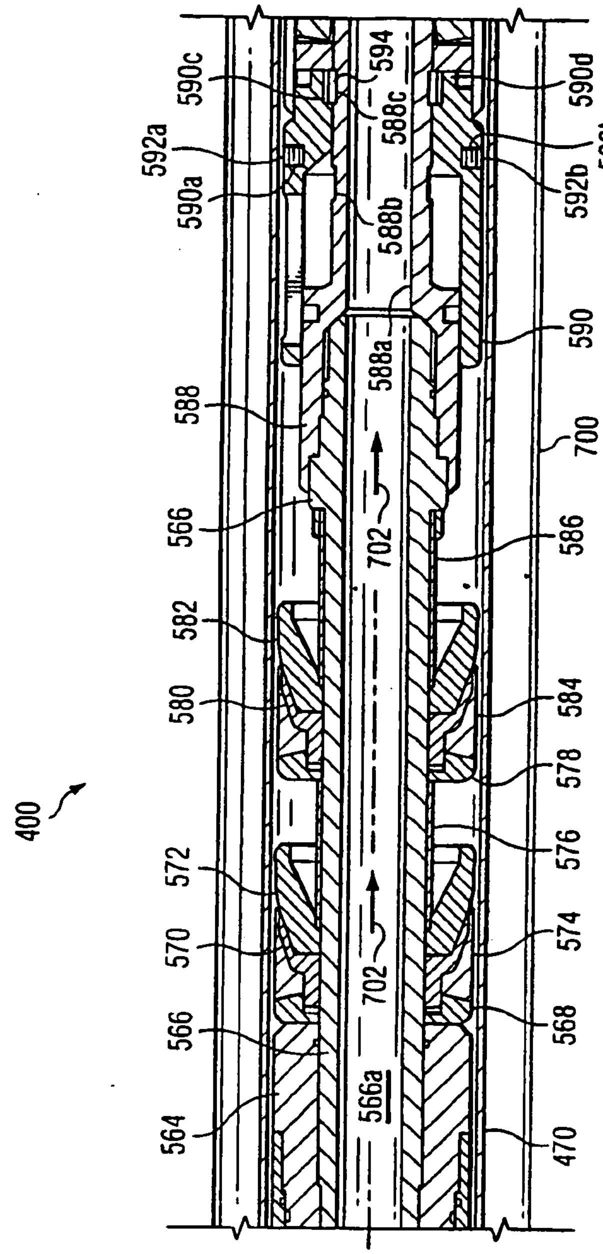

400
590c
592a
590a
594
588c
588b
590d
590b
592b
590
588a
588
700
566
702
586
582
580
584
578
572
576
570
574
566
568
564
566a
470

Fig. 29j

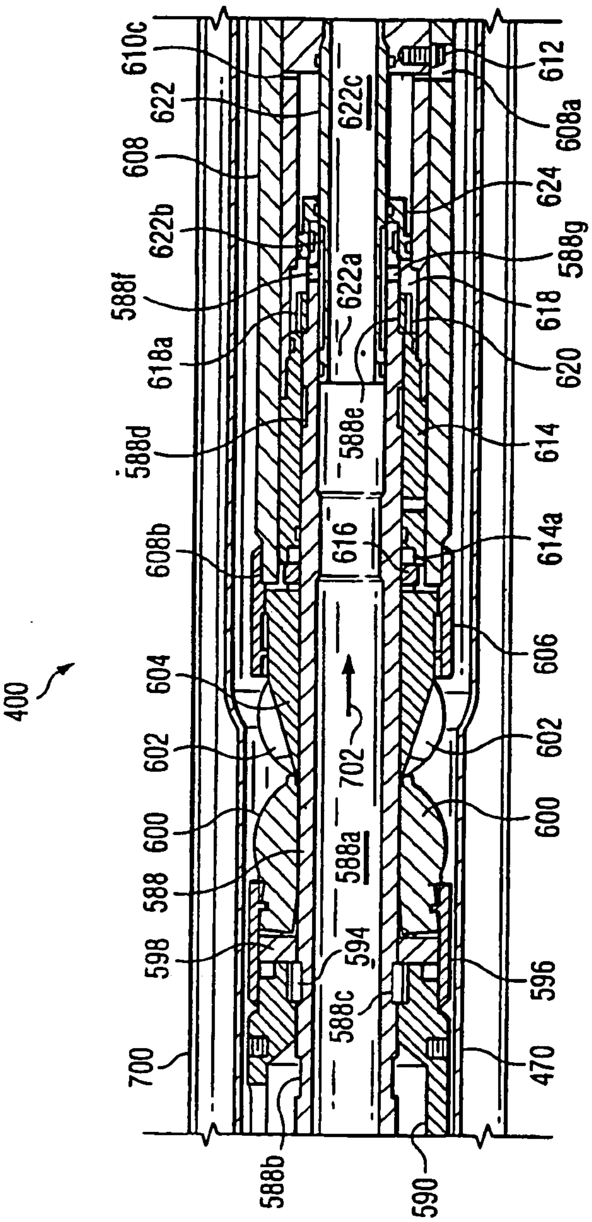

400
610c
622
608
622b
588f
618a
588d
608b
604
602
600
588
598
700
588b
622c
622a
588e
616
702
588a
594
588c
590
612
608a
624
588g
618
620
614
614a
606
602
600
596
470

Fig. 29k

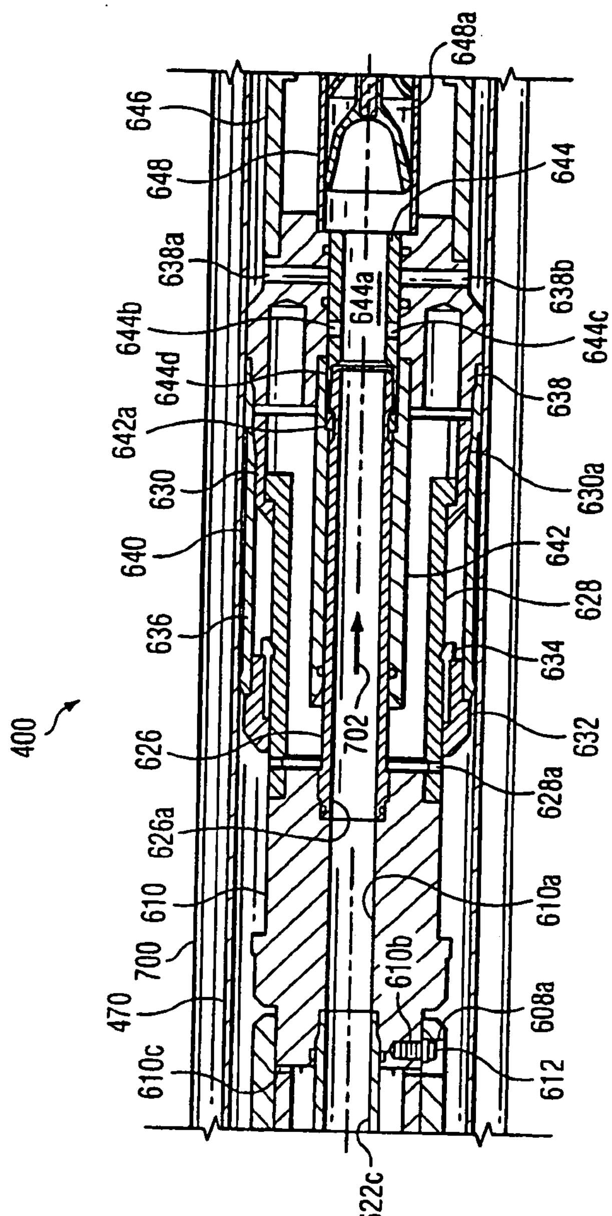

400
646
648
638a
644b
644d
642a
630
640
636
626
626a
610
700
470
610c
648a
644
644a
638b
644c
638
630a
642
628
634
632
628a
610a
608a
612
610b
702
622c

Fig. 29l

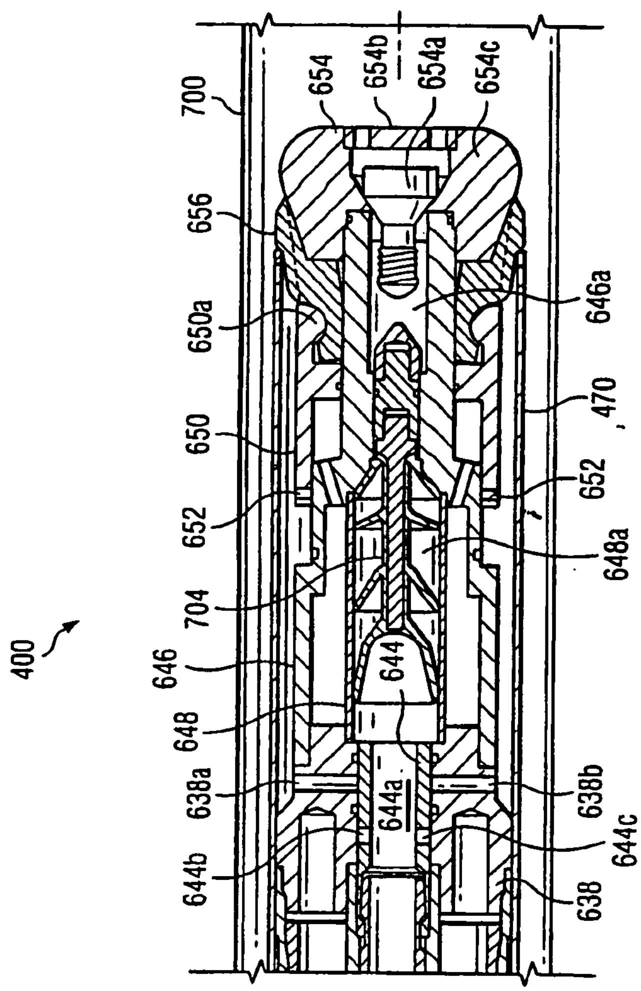

400
700
654
654b
654a
654c
656
650a
646a
650
470
652
652
704
648a
646
644
648
638a
644a
638b
644b
644c
638

Fig. 29m

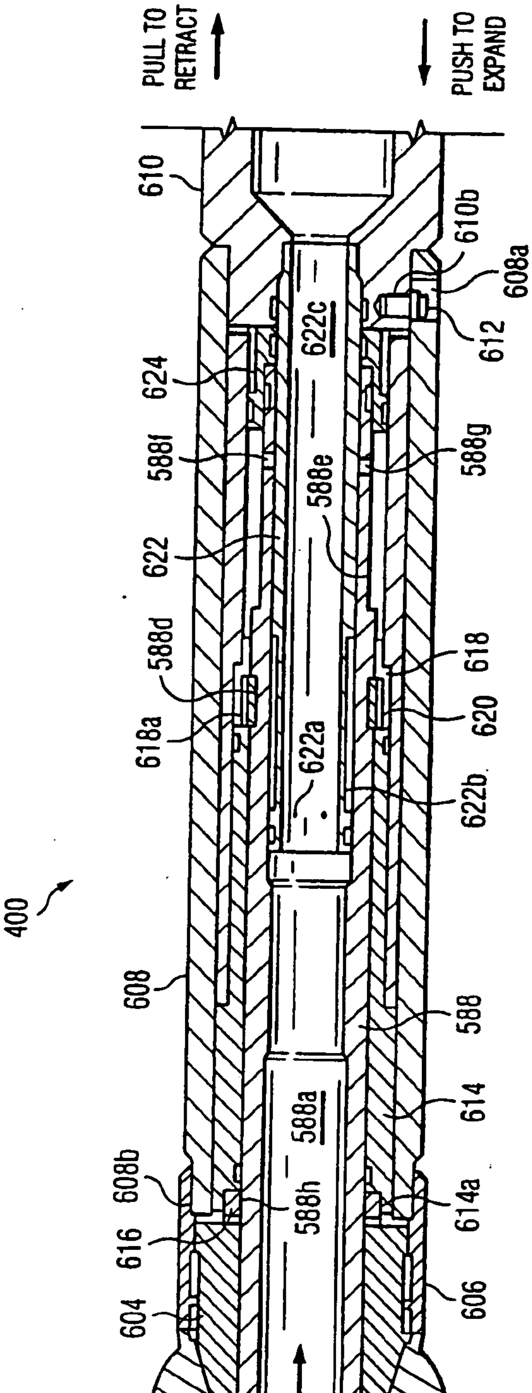

PULL TO RETRACT
PUSH TO EXPAND
610
610b
608a
612
624
588f
588g
588e
622c
622
588d
618
618a
620
622a
622b
400
608
588
614
588a
608b
588h
614a
616
604
606
600
600
702
596

Fig. 30a

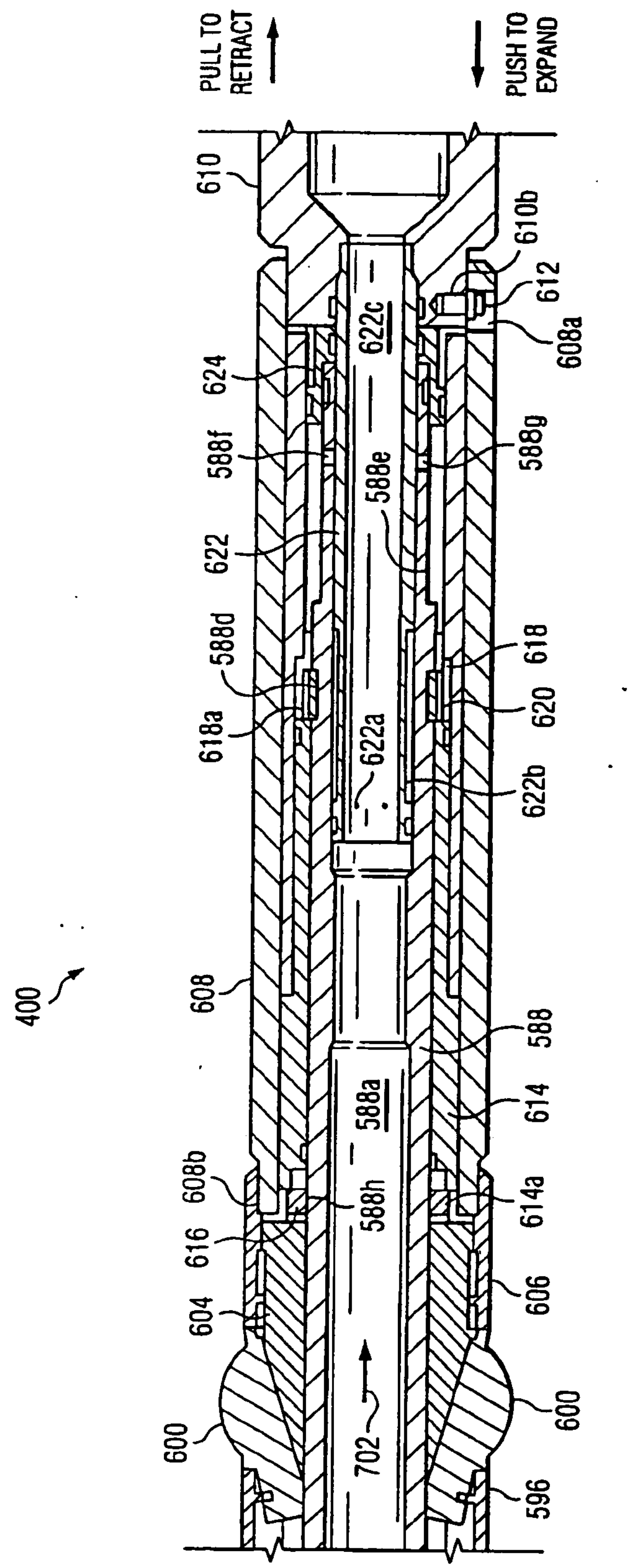

PULL TO RETRACT
PUSH TO EXPAND
610
610b
612
608a
624
588f
588g
622c
588e
622
588d
618
618a
620
622a
622b
400
608
588
614
588a
608b
614a
588h
616
606
604
600
600
702
596

Fig. 30b

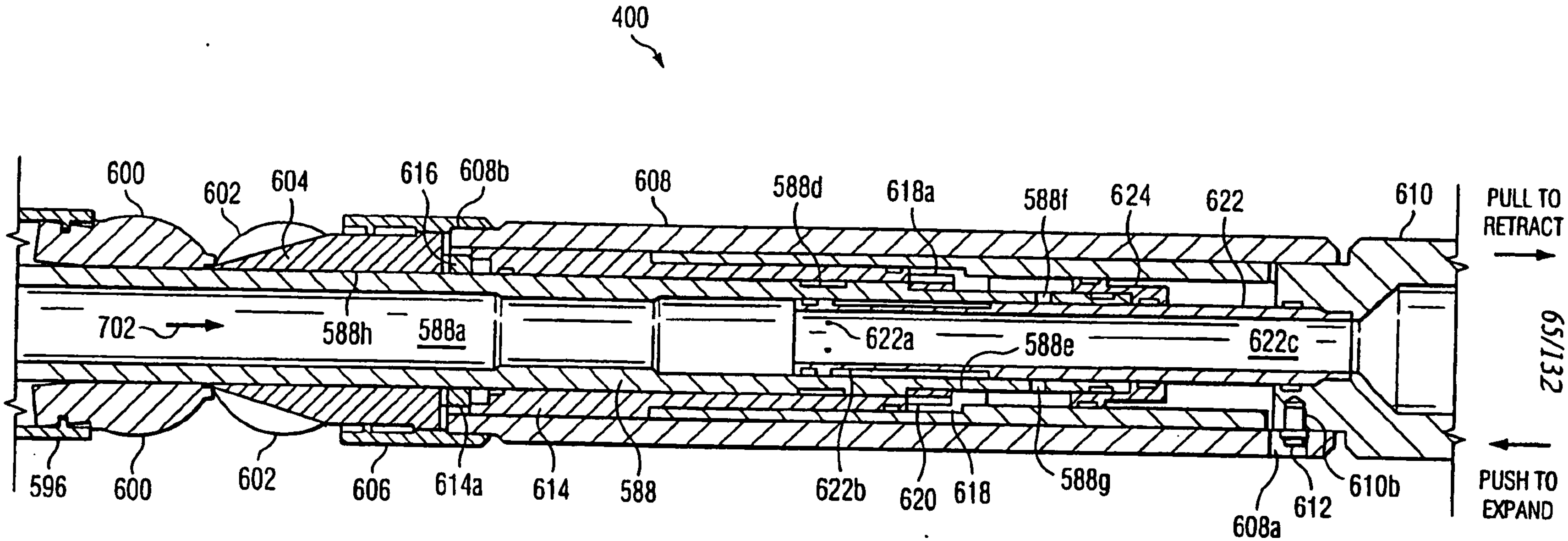

400
600
602
604
616
608b
608
588d
618a
588f
624
622
610
PULL TO RETRACT
702
588h
588a
622a
588e
622c
596
600
602
606
614a
614
588
622b
620
618
588g
608a
612
610b
PUSH TO EXPAND

Fig. 30c

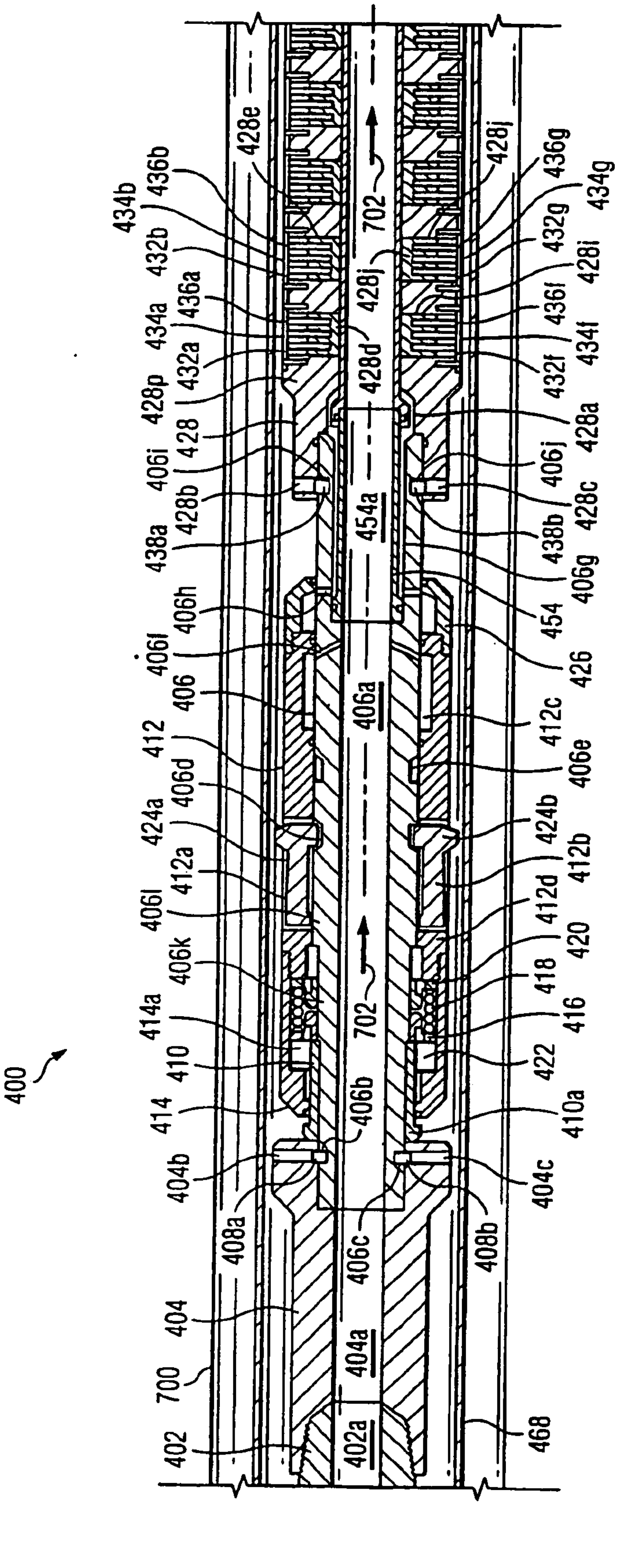

400
402
402a
404
404a
404b
404c
406
406a
406b
406c
406d
406e
406g
406h
406i
406j
406k
406l
408a
408b
410
410a
412
412a
412b
412c
412d
414
414a
416
418
420
422
424a
424b
426
428
428a
428b
428c
428d
428e
428i
428j
428p
432a
432b
432f
432g
434a
434b
434f
434g
436a
436b
436f
436g
438a
438b
454
454a
468
700
702

Fig. 31a

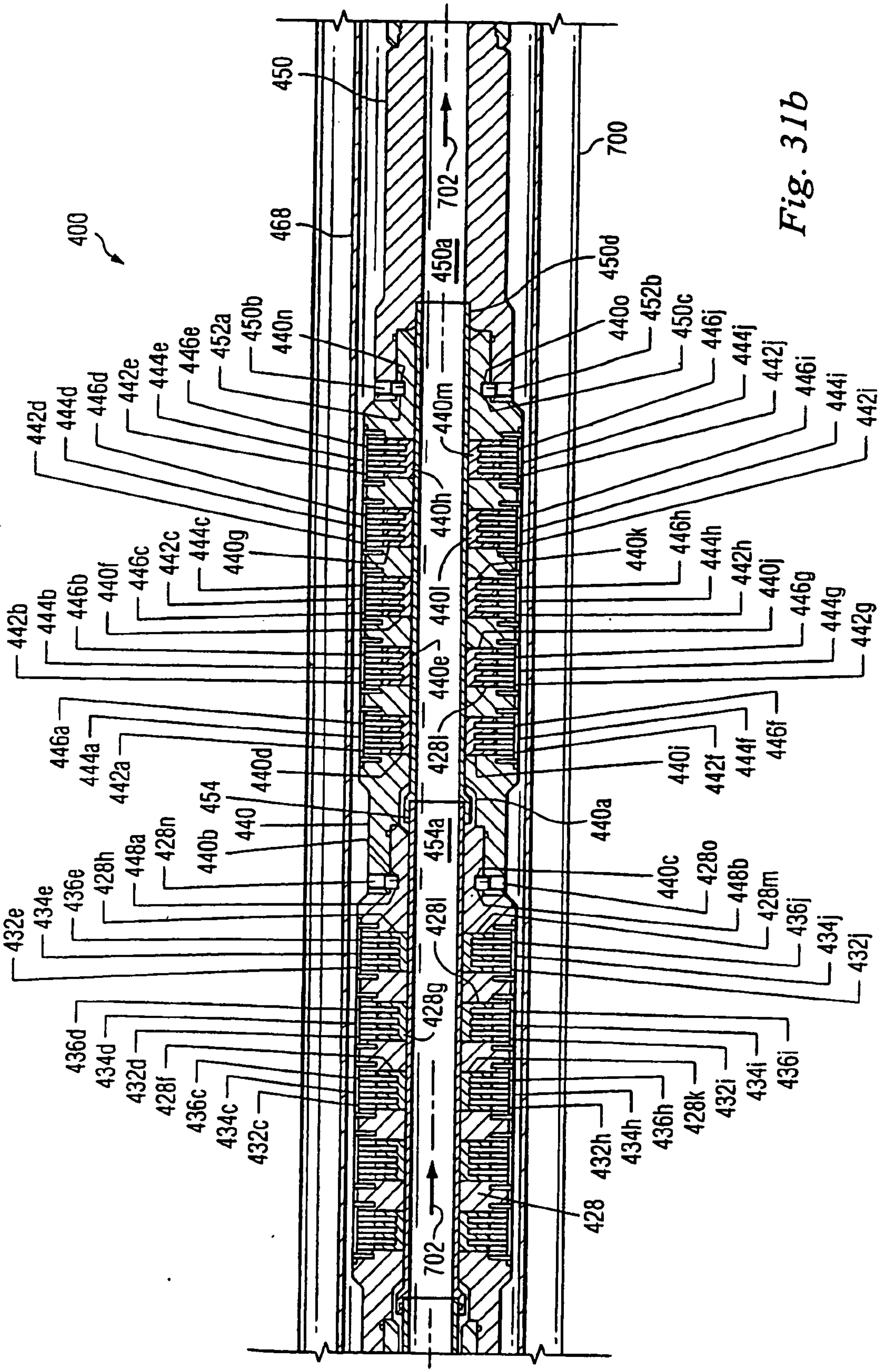

400
450
468
700
702
450a
450d
450b
450c
450n
452a
452b
440o
440n
440m
440h
440l
440e
440k
440j
440g
440f
440i
440d
440a
440
440b
440c
454
454a
446e
444e
442e
446d
444d
442d
446c
444c
442c
446b
444b
442b
446a
444a
442a
446j
444j
442j
446i
444i
442i
446h
444h
442h
446g
444g
442g
446f
444f
442f
428n
428o
428m
428l
428h
428g
428f
428k
428i
428
448a
448b
436e
434e
432e
436j
434j
432j
436d
434d
432d
436i
434i
432i
436c
434c
432c
436h
434h
432h

Fig. 31b

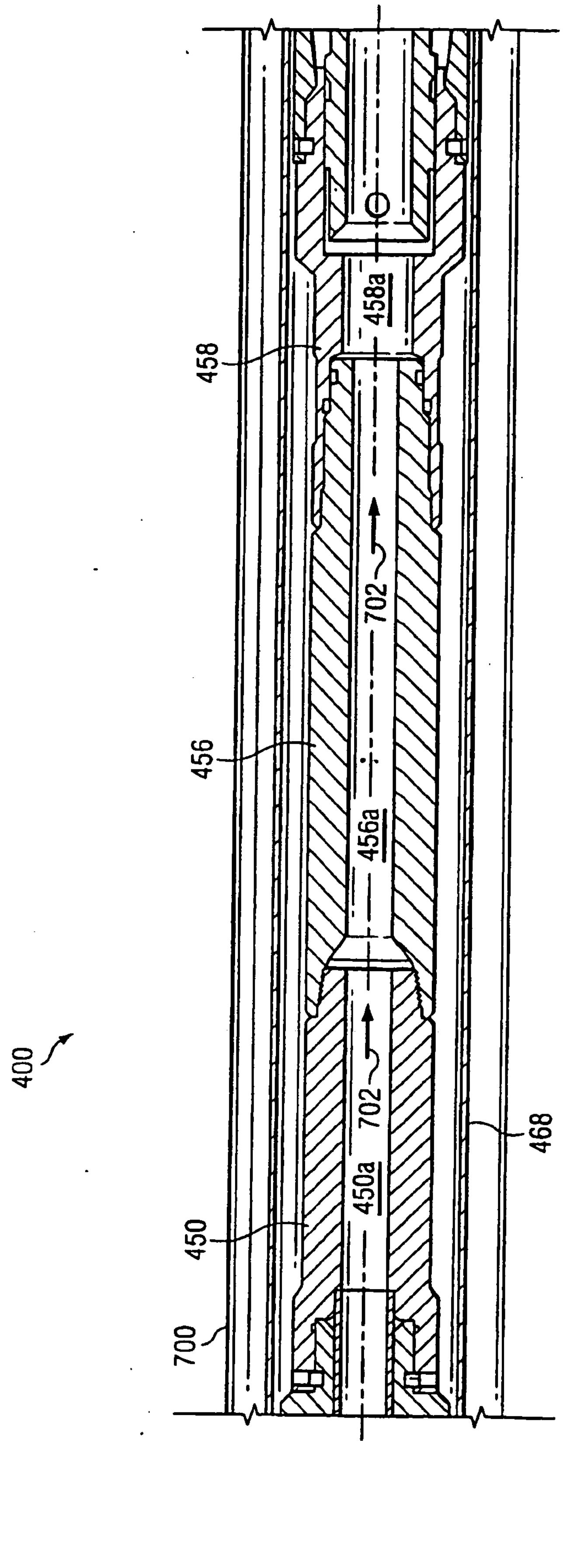


Fig. 31c

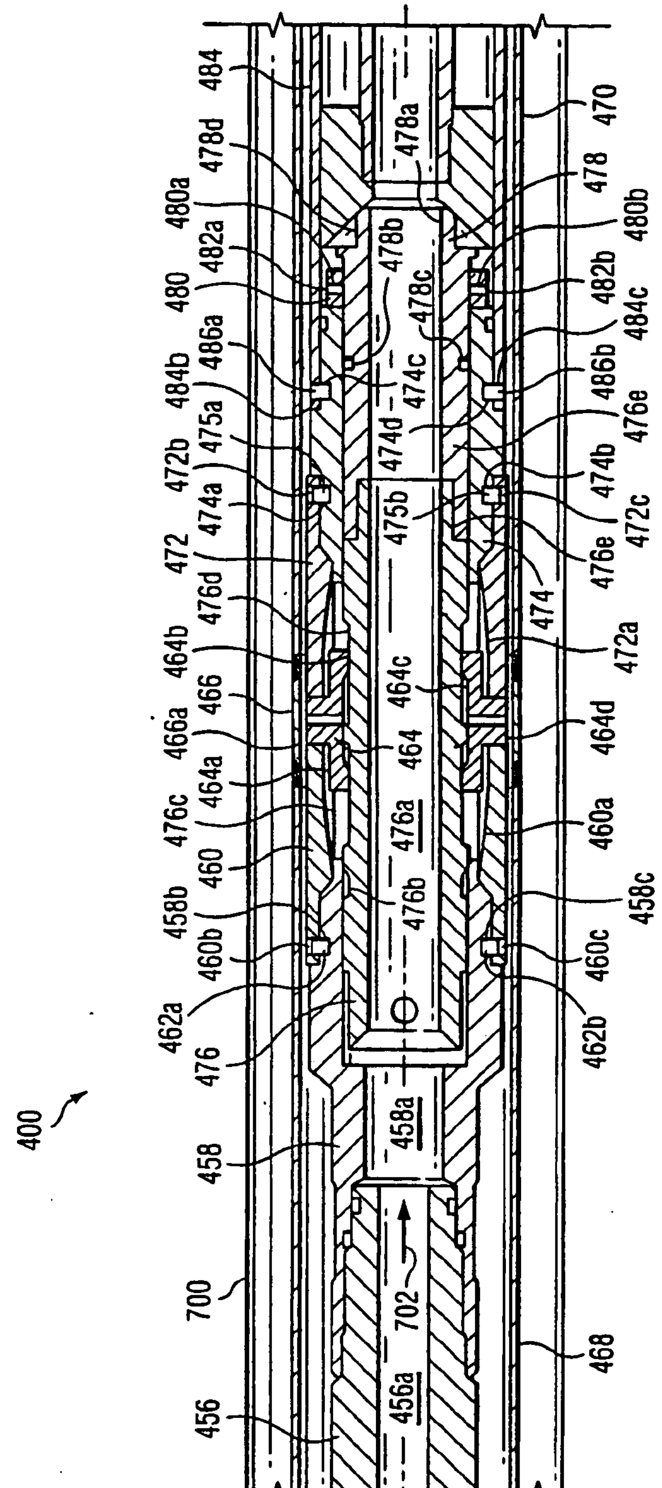

400
456
456a
458
458a
458b
458c
460
460a
460b
460c
462a
462b
464
464a
464b
464c
464d
466
466a
468
470
472
472a
472b
472c
474
474a
474b
474c
474d
475a
475b
476
476a
476b
476c
476d
476e
478
478a
478b
478c
478d
480
480a
480b
482a
482b
484
484b
484c
486a
486b
700
702

Fig. 31d

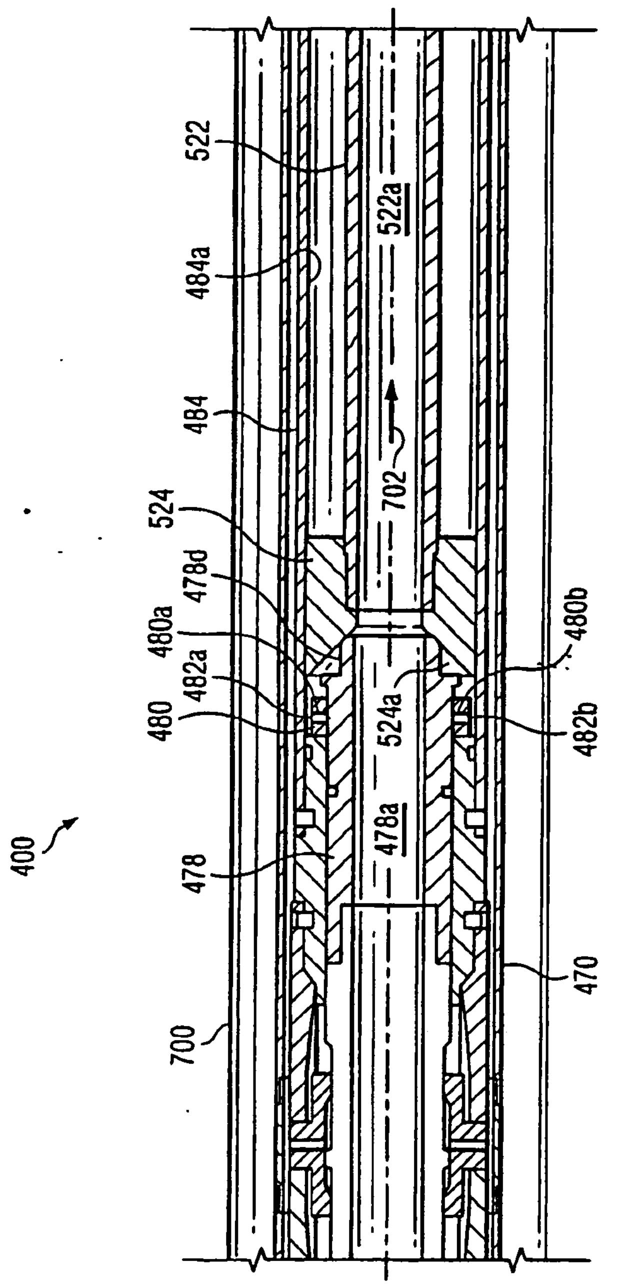

522
522a
484a
484
702
524
478d
480a
482a
480
524a
478a
400
478
700
470
482b
480b

Fig. 31e

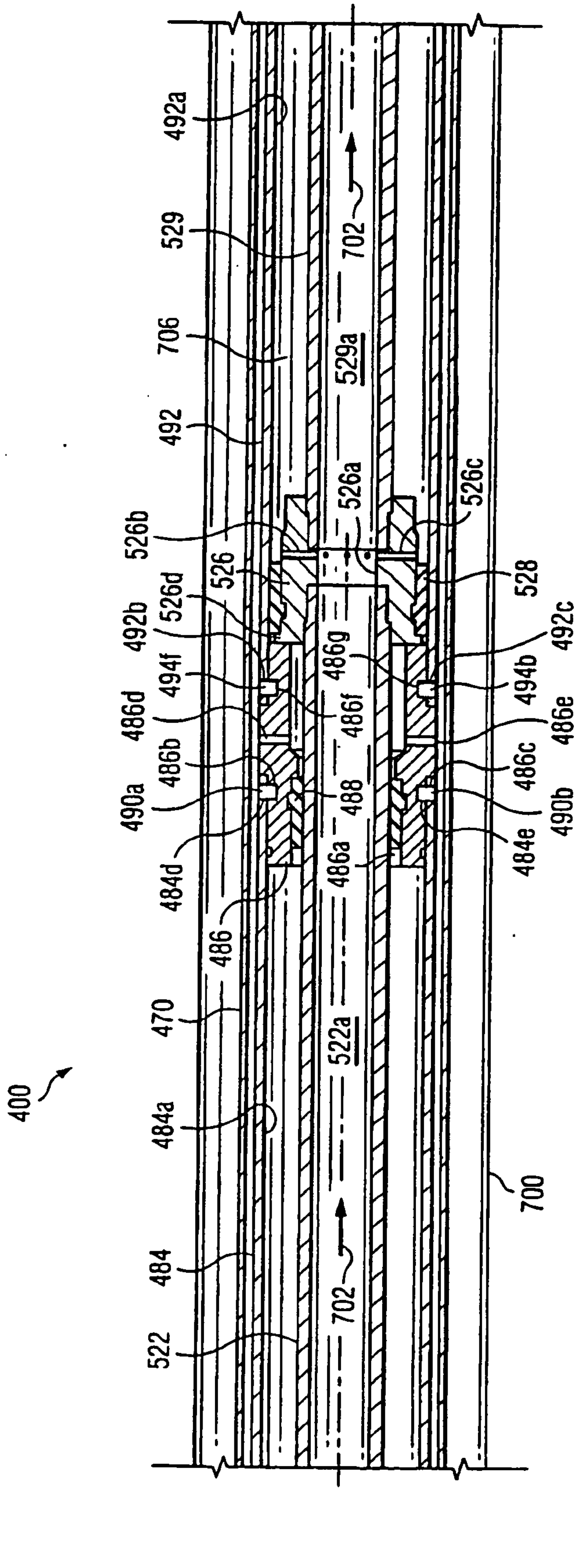

400
492a
529
706
492
526b
702
529a
526a
526c
526
526d
492b
494f
486d
486b
490a
484d
486
470
484a
484
522
528
492c
486g
486f
494b
486e
486c
488
486a
484e
490b
522a
700

Fig. 31f

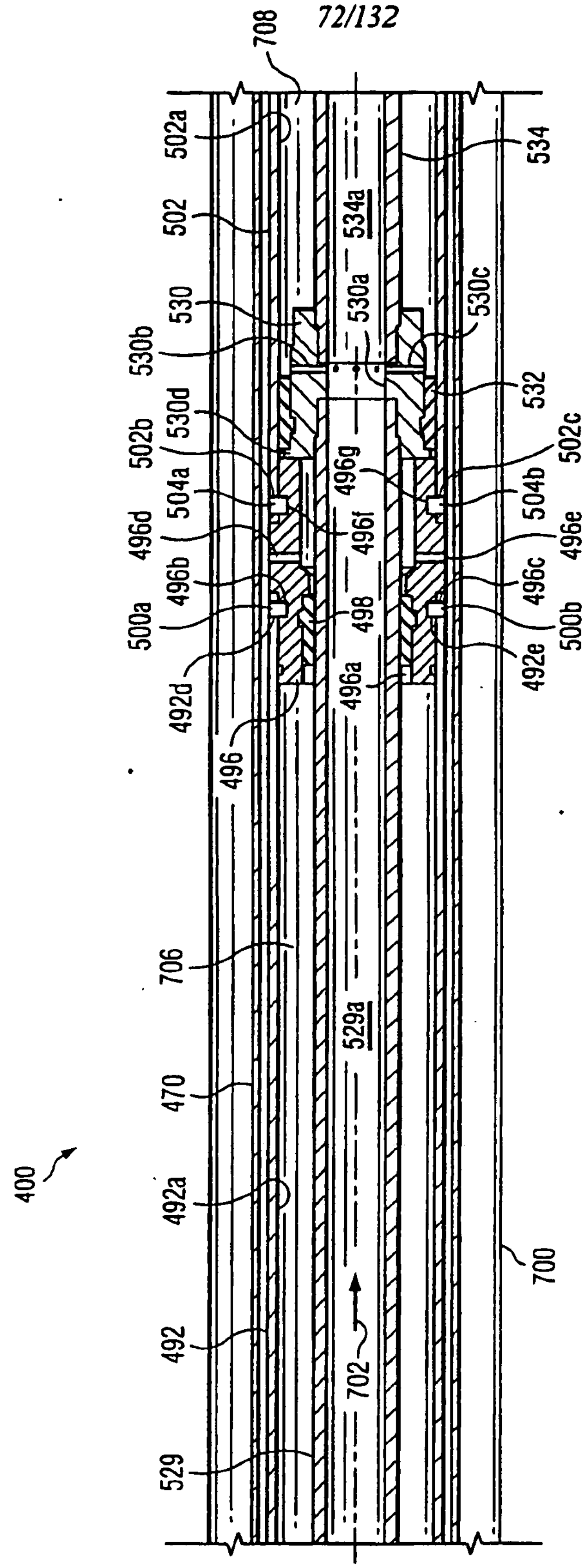
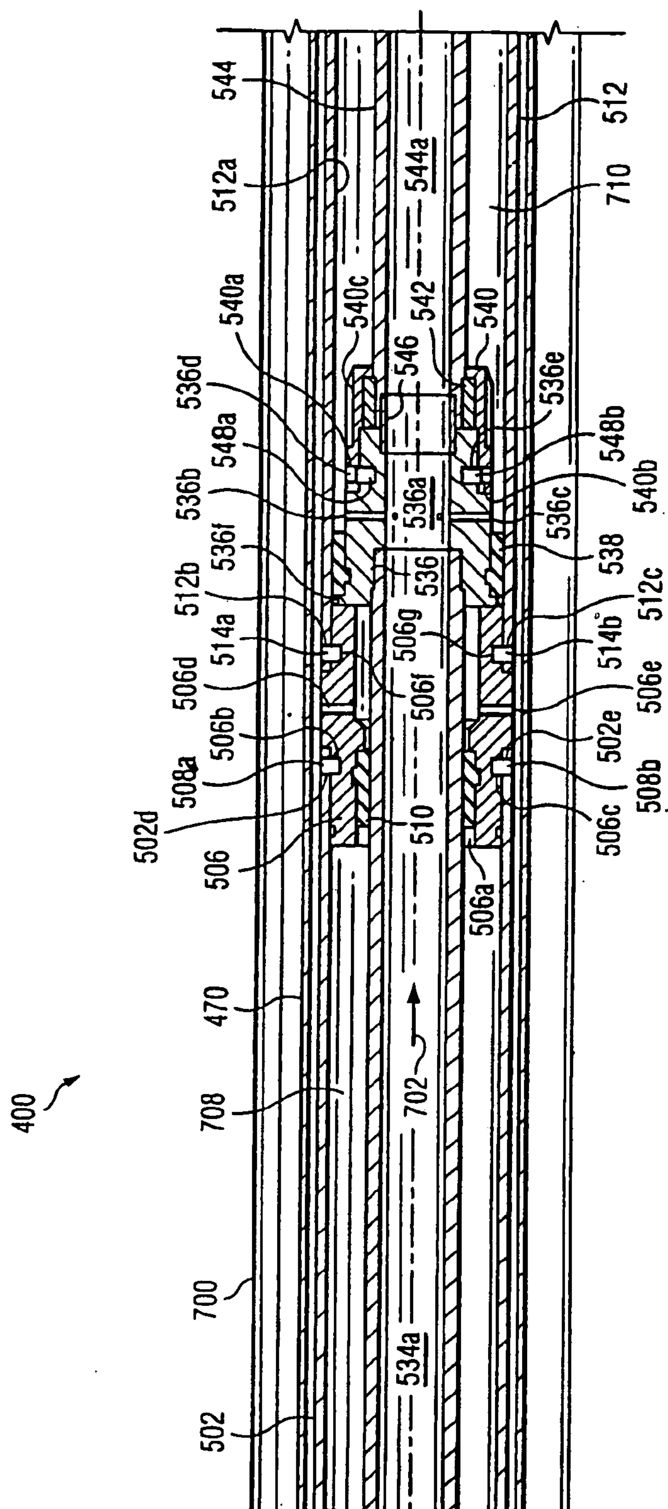
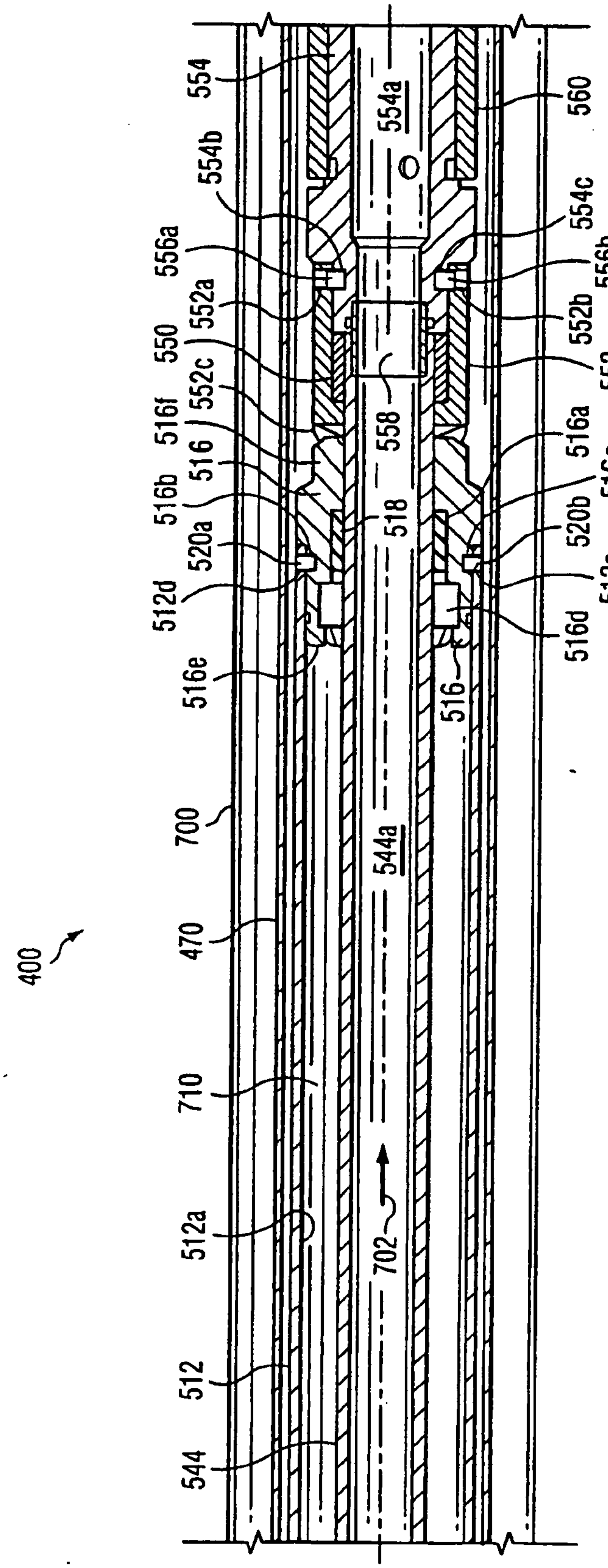

708
502a
502
530
530b
530d
502b
504a
496d
496b
500a
492d
496
706
470
400
492a
492
529
534
534a
530a
530c
532
496g
502c
504b
496f
496e
496c
498
500b
492e
496a
529a
702
700

Fig. 31g



400
544
512a
544a
512
710
540a
540c
542
540
546
536d
536e
548a
548b
536b
536a
536c
540b
536f
536
538
512b
512c
514a
506g
514b
506d
506f
506e
506b
502e
508a
508b
502d
510
506c
506
506a
470
708
702
700
534a
502
534

Fig. 31h



554
554a
560
554b
554c
556a
556b
552a
552b
550
552
552c
558
516f
516
516a
516b
518
516c
520a
520b
512d
512e
516d
516e
516
700
544a
400
470
710
702
512a
512
544

Fig. 31i

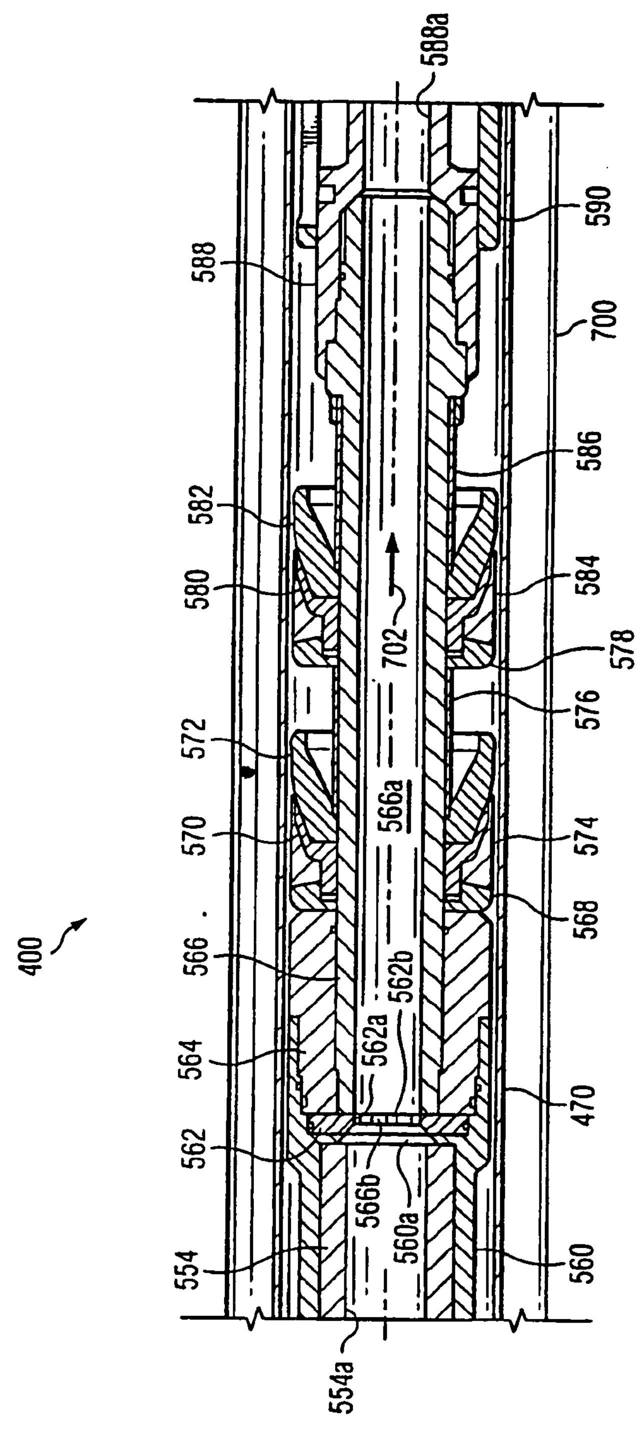

400
588a
590
588
700
586
582
580
584
578
702
572
576
566a
570
574
568
566
562b
562a
564
470
562
566b
560a
554
560
554a

Fig. 31j

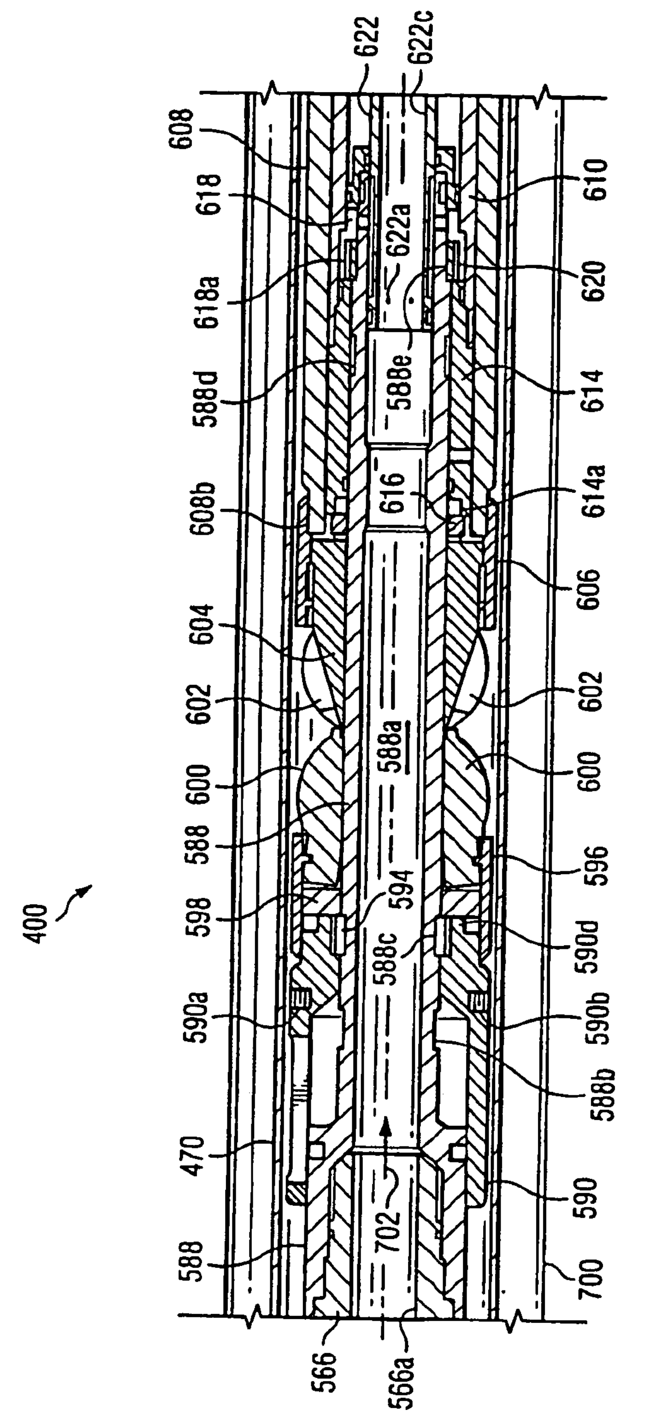
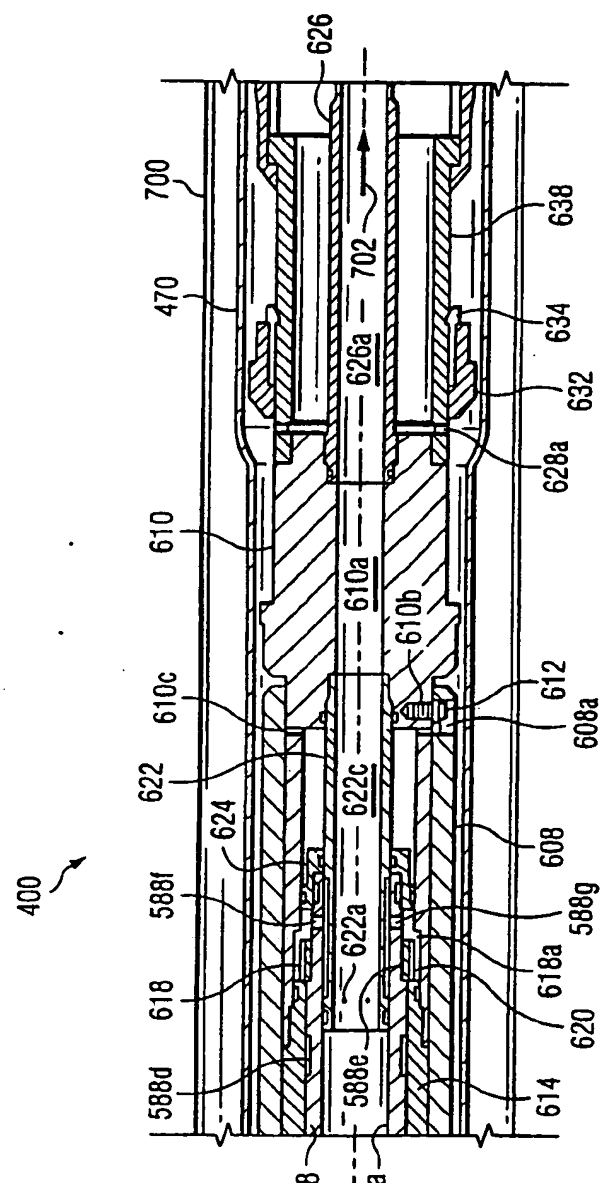

400
608
618
618a
588d
608b
604
602
600
588
598
590a
470
588
566
566a
622
622c
622a
588e
616
588a
594
588c
702
610
620
614
614a
606
602
600
596
590d
590b
588b
590
700

Fig. 31k



400
700
470
610
610c
622
624
588f
618
588d
588
588a
588e
622a
622c
610a
610b
626a
702
626
638
634
632
628a
612
608a
608
588g
618a
620
614

Fig. 31l

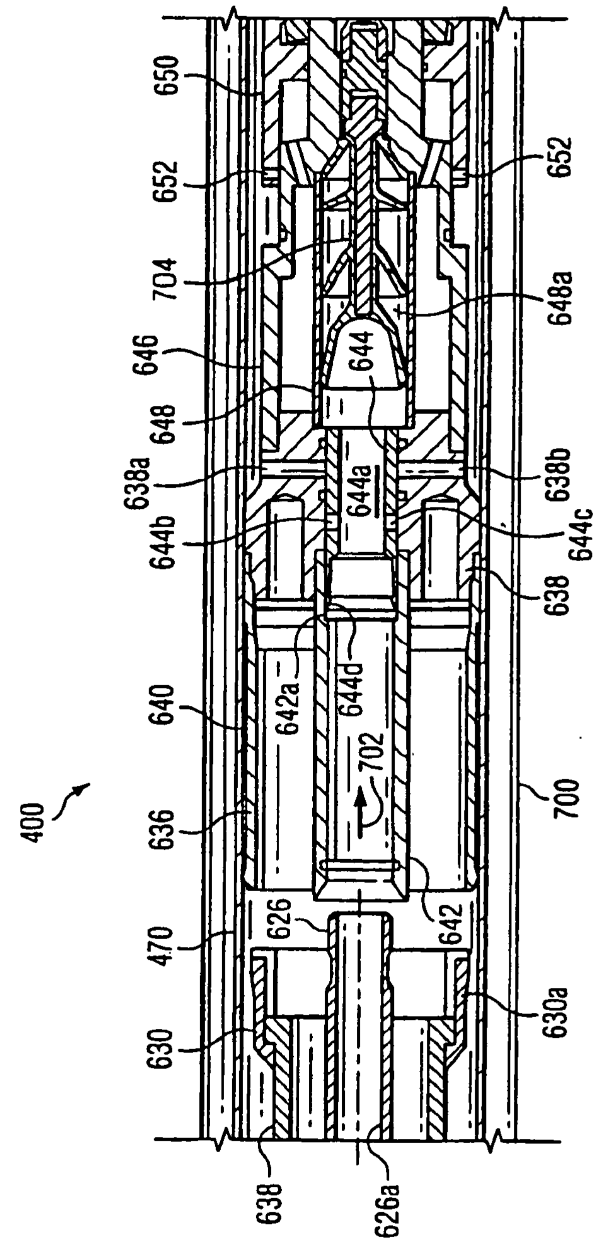
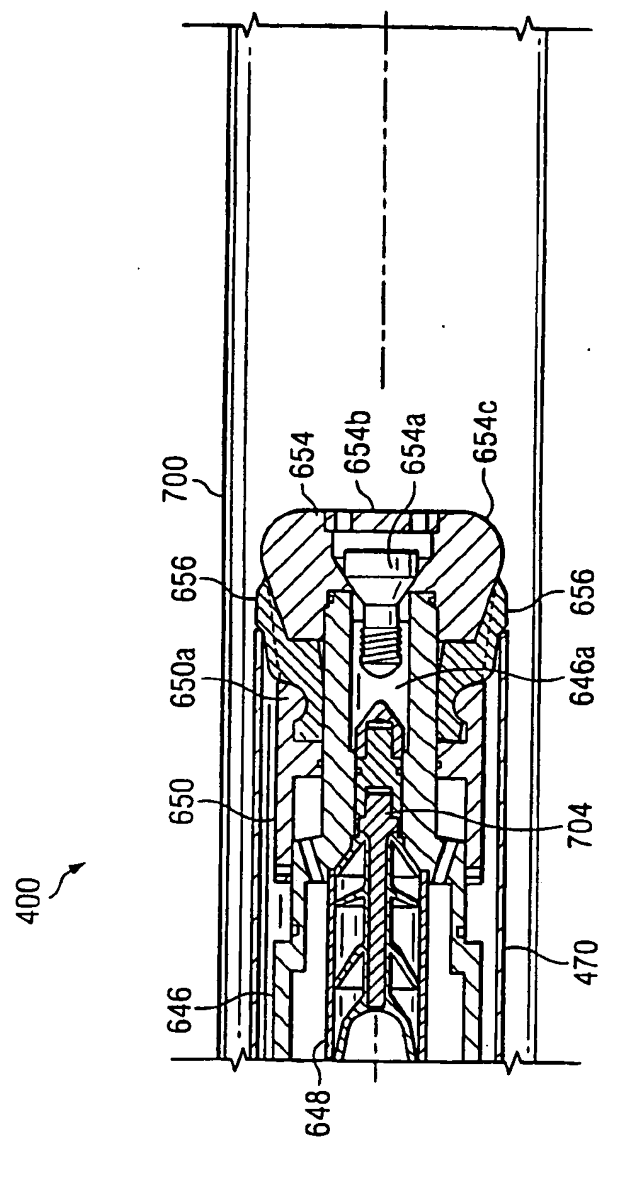

400
650
652
652
704
648a
646
644
648
638a
644a
638b
644b
644c
638
640
642a
644d
702
636
700
470
626
642
630
630a
638
626a

Fig. 31m



700
654
654b
654a
654c
656
656
650a
646a
650
704
400
470
646
648

Fig. 31n

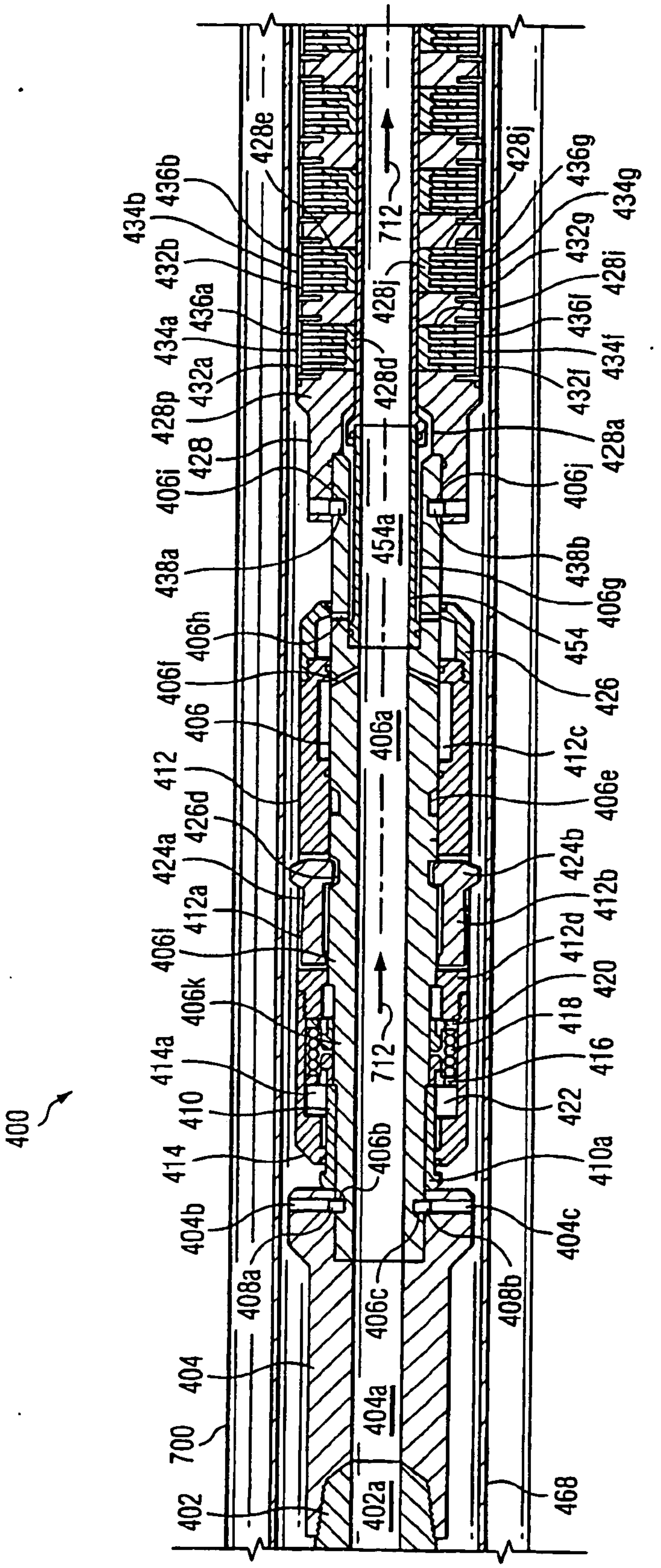

400
402
402a
404
404a
404b
404c
406b
406c
408a
408b
410
410a
414
414a
416
418
420
422
406k
406l
412a
412b
412d
424a
424b
426d
412
412c
406
406a
406e
406f
406h
426
454
454a
406g
438a
438b
406i
406j
428
428a
428p
428d
432a
434a
436a
432b
434b
436b
428e
428i
428j
432f
434f
436f
432g
434g
436g
712
700
468

Fig. 32a.

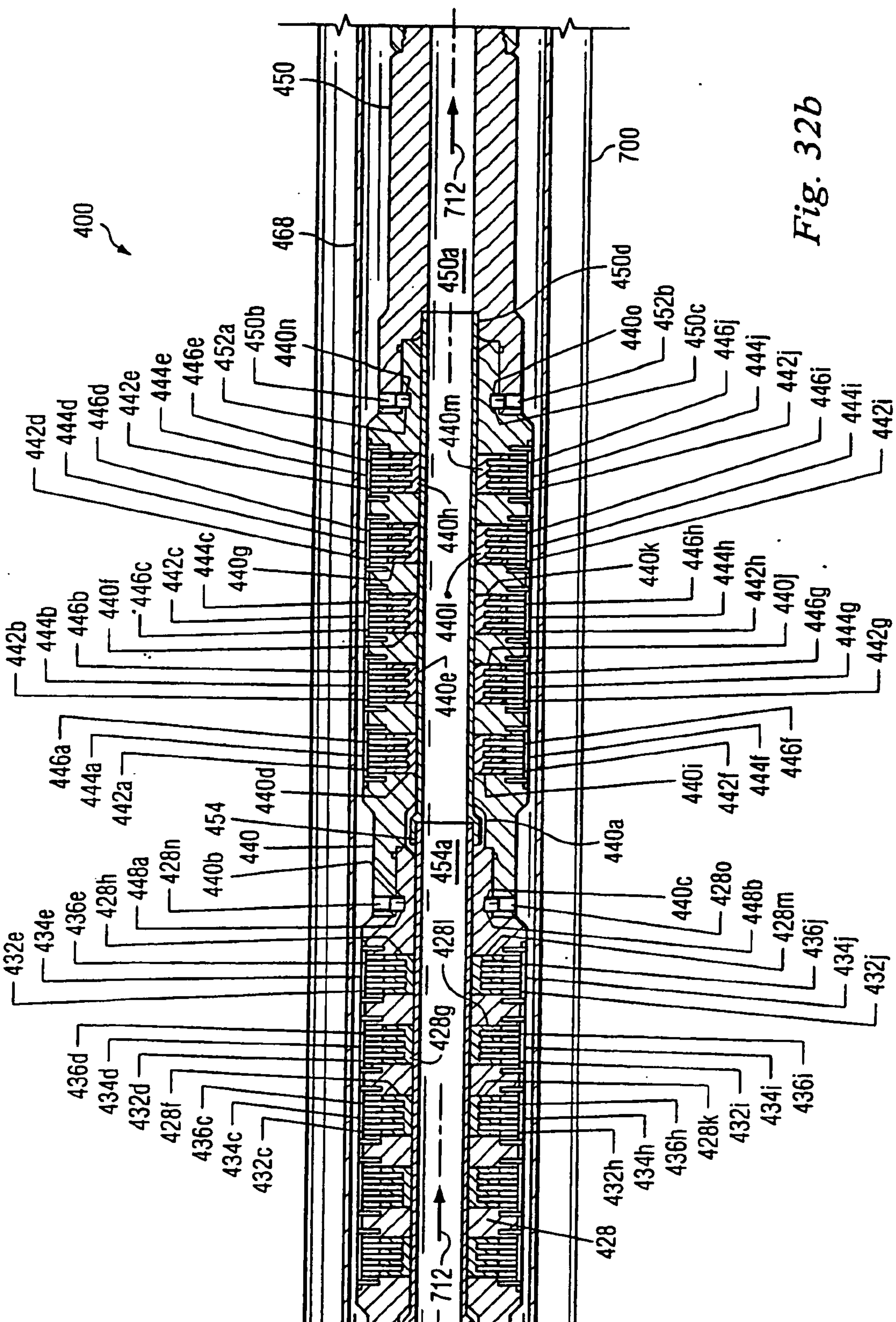

400
450
468
700
712
450a
450d
452b
450c
440o
446j
444j
442j
446i
444i
442i
440m
440h
440k
446h
444h
442h
440j
446g
444g
442g
440l
440e
440i
442f
444f
446f
440a
440c
428o
448b
428m
436j
434j
432j
428l
428g
436i
434i
432i
428k
436h
434h
432h
428
450b
440n
452a
446e
444e
442e
446d
444d
442d
440g
444c
442c
446c
440f
446b
444b
442b
446a
444a
442a
440d
454
454a
440
440b
428n
448a
428h
436e
434e
432e
436d
434d
432d
428f
436c
434c
432c

Fig. 32b

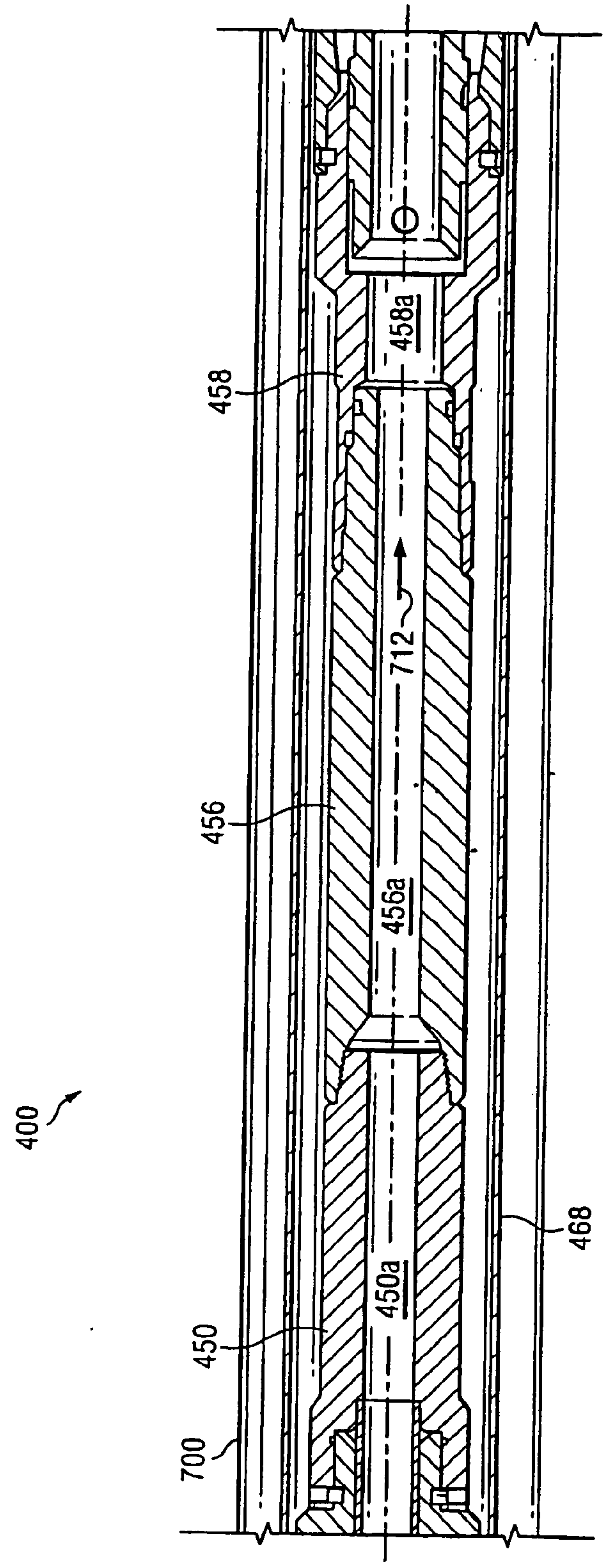


Fig. 32c

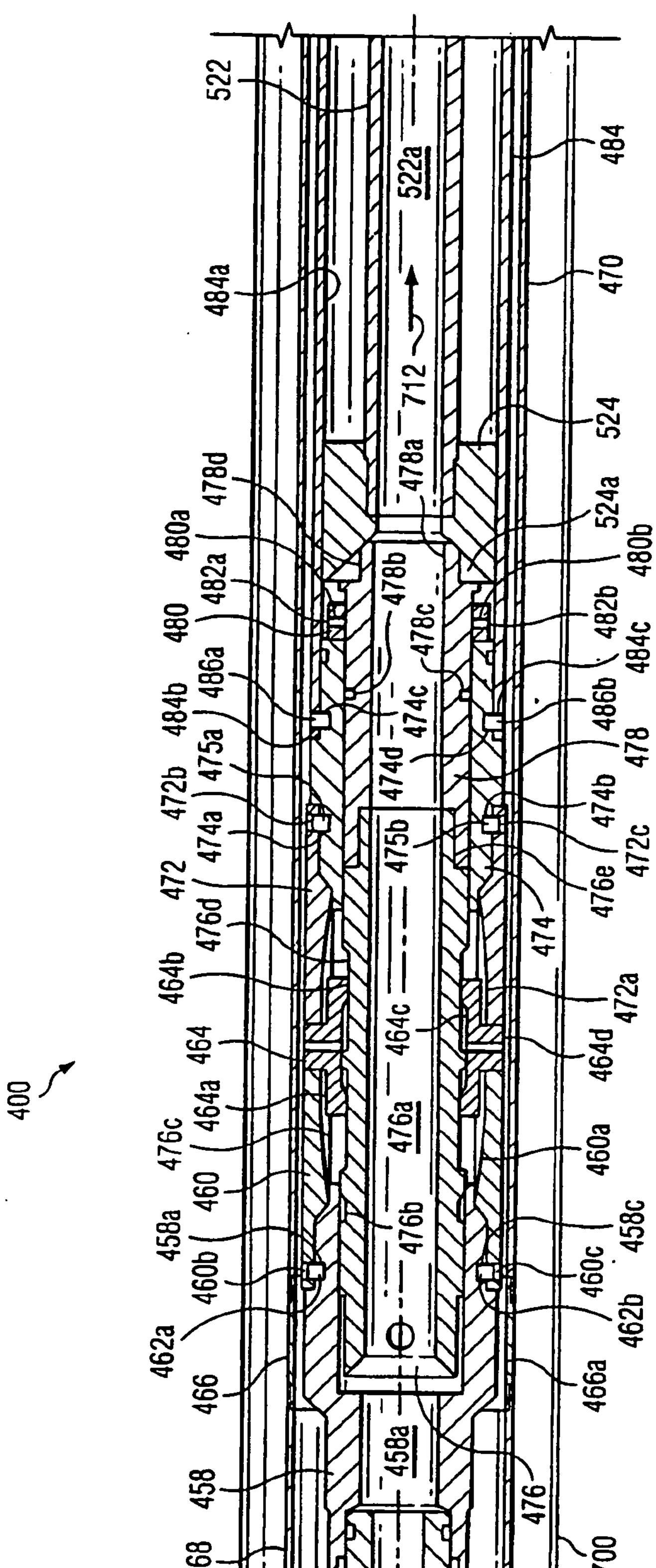

400
522
522a
484
484a
470
712
524
478a
478d
480a
524a
480b
478b
482a
478c
480
482b
486a
474c
484c
484b
486b
474d
475a
478
472b
474b
474a
475b
472c
476e
472
474
476d
464b
472a
464c
464
464d
464a
476a
476c
460a
460
476b
458a
458c
460b
460c
462a
462b
466
466a
458
458a
476
468
700

FIG. 32d

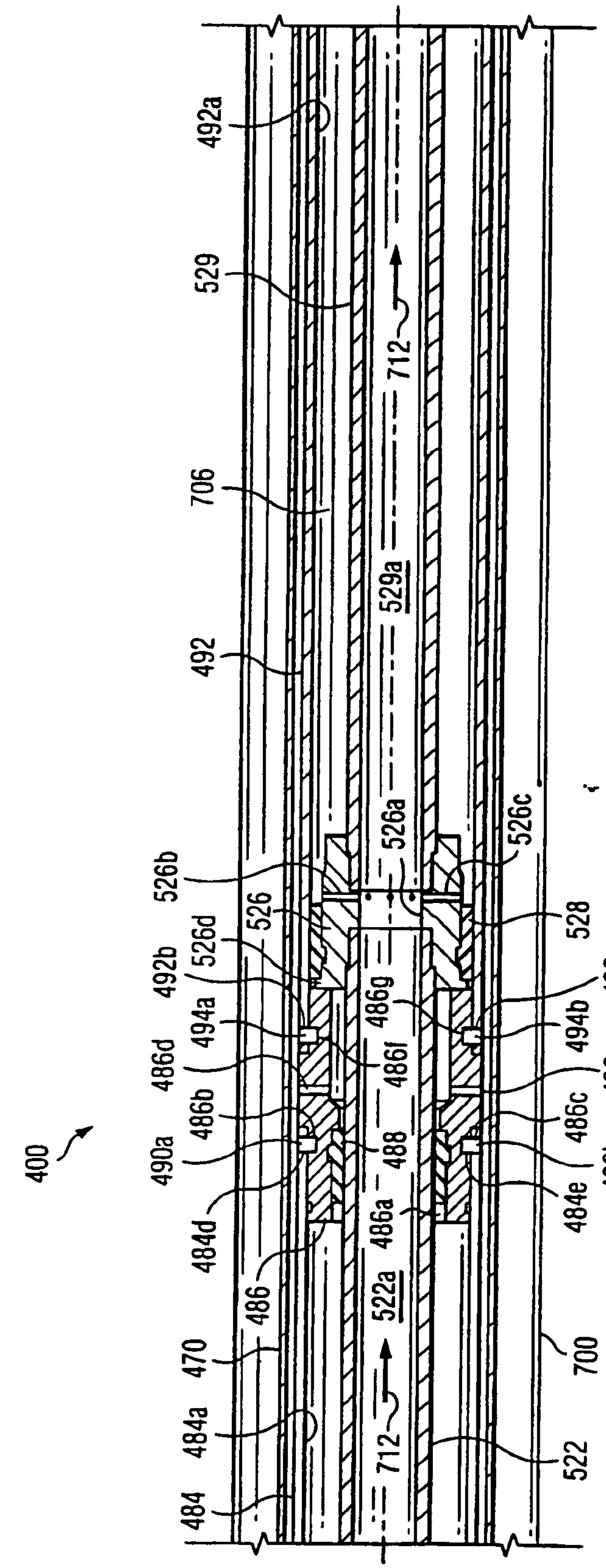

400
492a
529
712
706
529a
492
526a
526b
526c
526
526d
528
492b
486g
492c
494a
494b
486d
486f
486e
486b
486c
490a
488
490b
484d
486a
484e
486
522a
470
700
484a
712
522
484

Fig. 32e

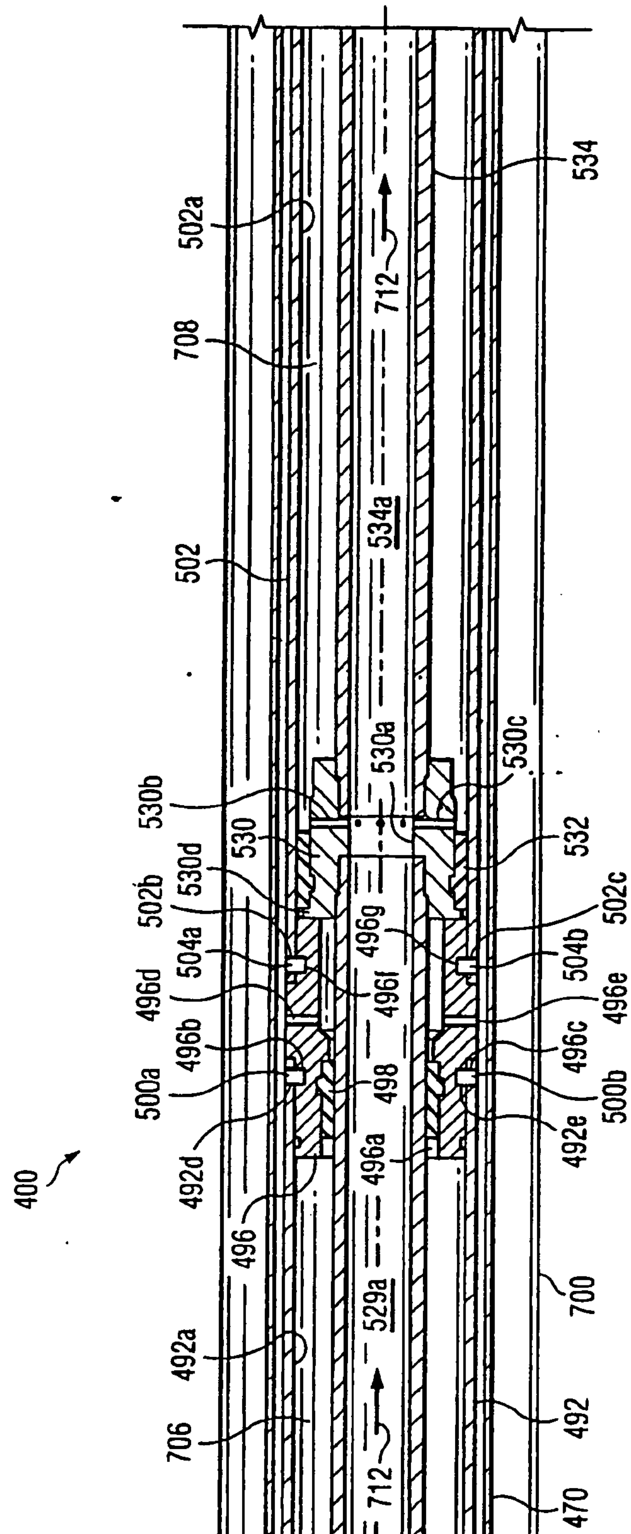

400
502a
708
502
530b
530
530d
502b
504a
496d
496b
500a
492d
496
492a
706
712
534a
530a
496g
496f
498
496a
529a
534
530c
532
502c
504b
496e
496c
500b
492e
700
492
470

Fig. 32f

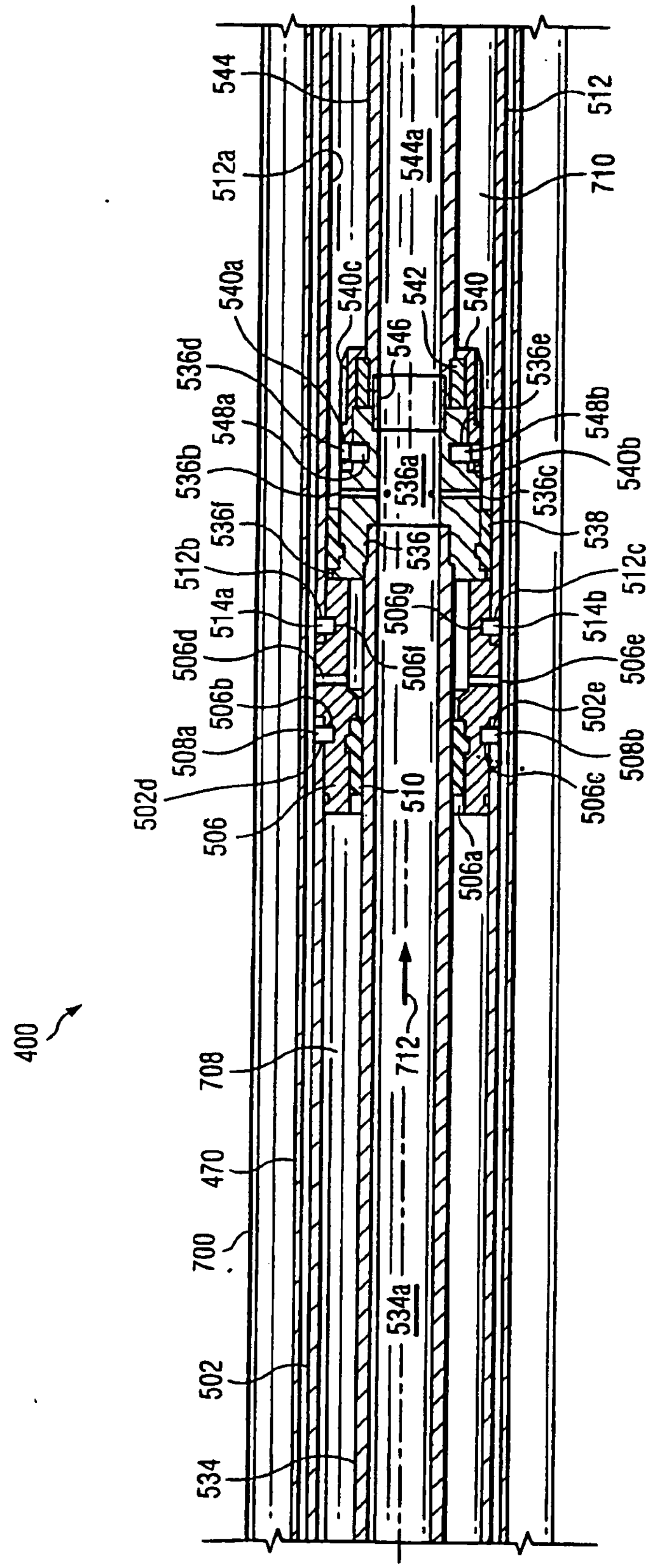
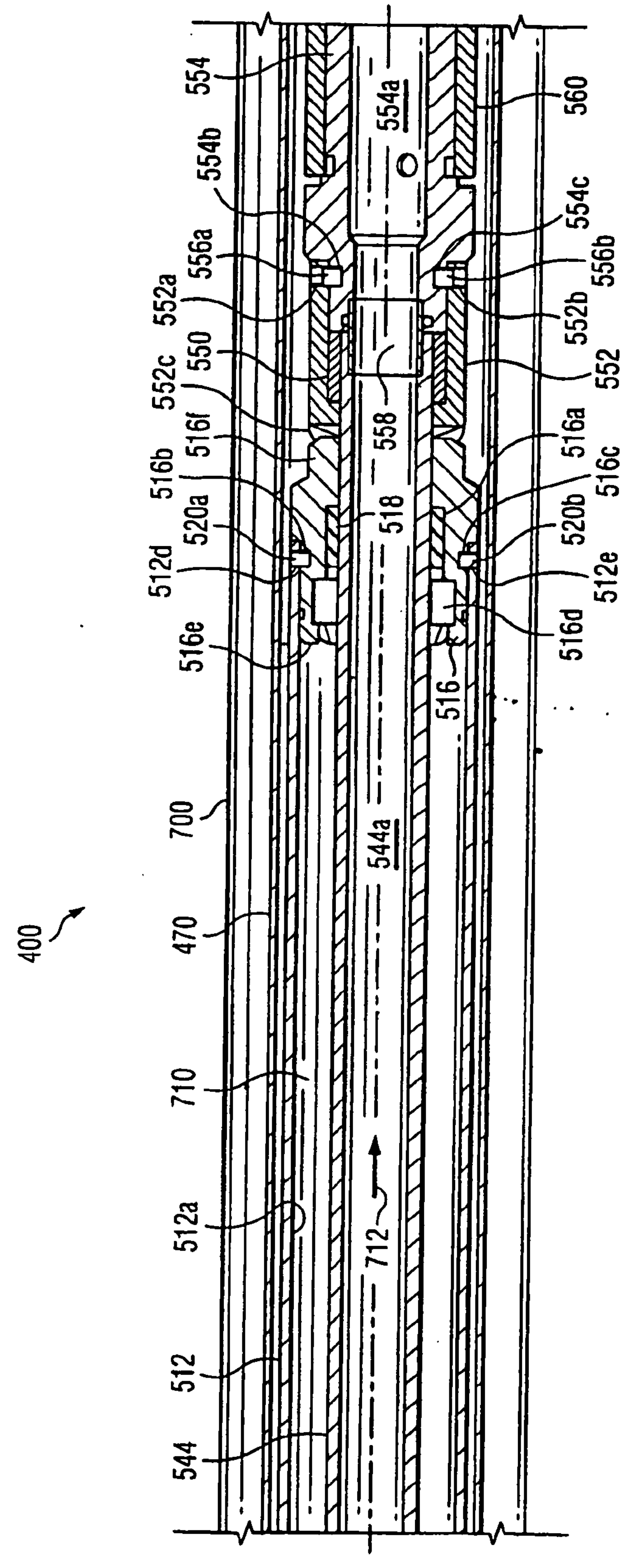
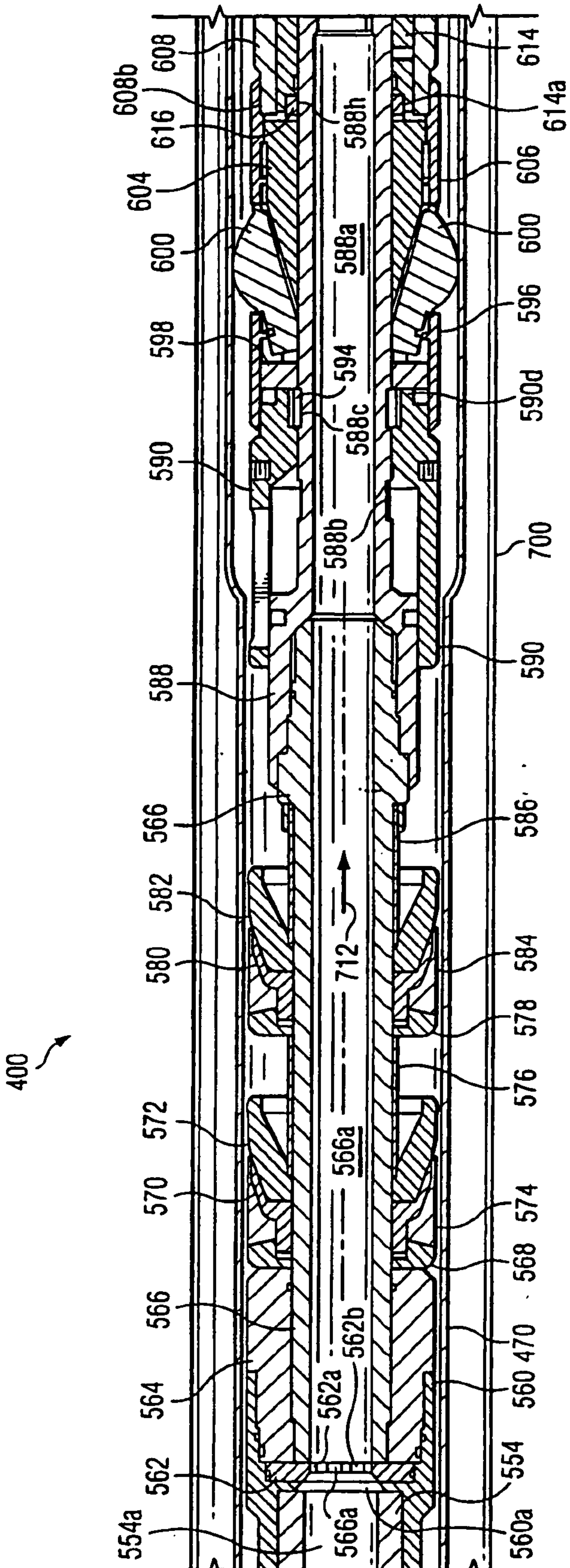

544
512a
544a
512
710
540a
540c
542
540
546
536d
536e
548a
536a
548b
536b
540b
536c
536f
536
538
512b
512c
506g
514a
514b
506d
506f
506e
506b
502e
508a
508b
502d
510
506c
506
506a
400
708
712
470
700
534a
502
534

Fig. 32g



554
554a
560
554b
554c
556a
556b
552a
552b
550
552
552c
558
516f
516a
516b
516c
520a
518
520b
512d
512e
516e
516d
516
700
544a
400
470
710
512a
712
512
544

Fig. 32h



608
608b
616
604
600
598
590
588
566
582
580
572
570
566
564
562
554a
614
614a
606
600
596
590d
700
590
586
584
578
576
574
568
470
560
554
560a
588h
588a
594
588c
588b
712
566a
562a
562b
566a
400

Fig. 32i

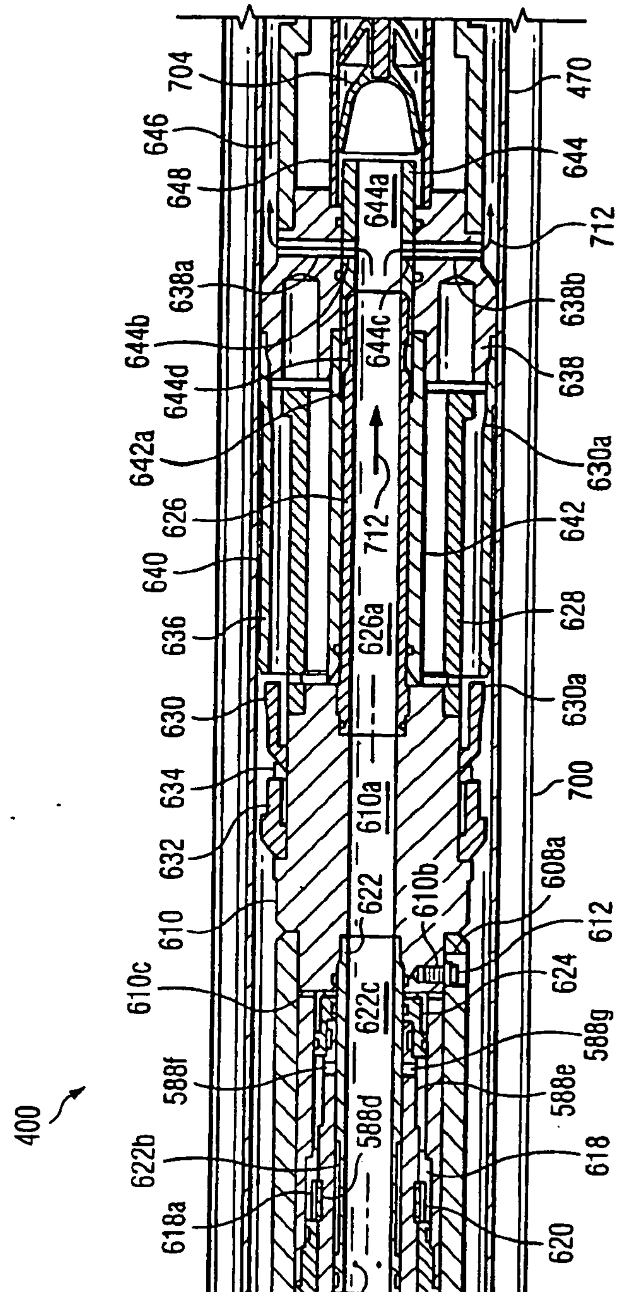

400
704
646
648
638a
644b
644d
642a
626
640
636
630
634
632
610
610c
588f
622b
618a
608
608b
588
604
600
470
644
712
638b
638
630a
642
628
700
608a
612
624
588g
588e
618
620
614
614a
606
644a
644c
626a
610a
622
610b
622c
588d
622a
616
588a

Fig. 32j

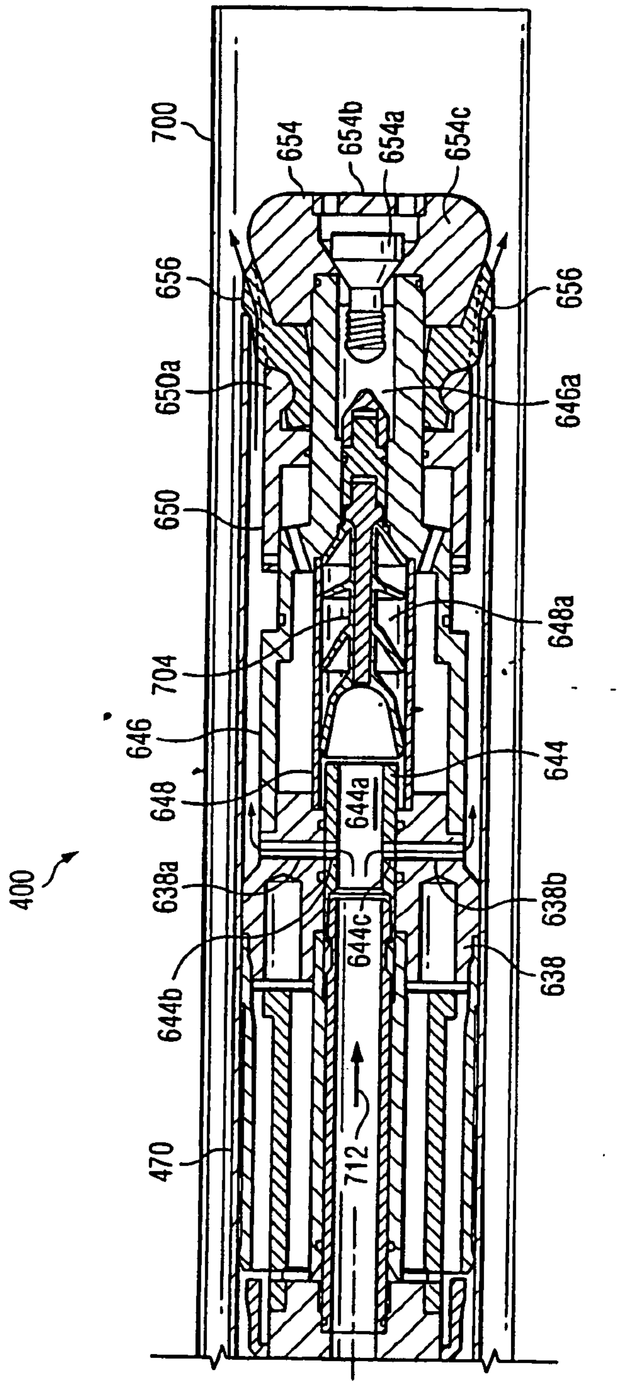
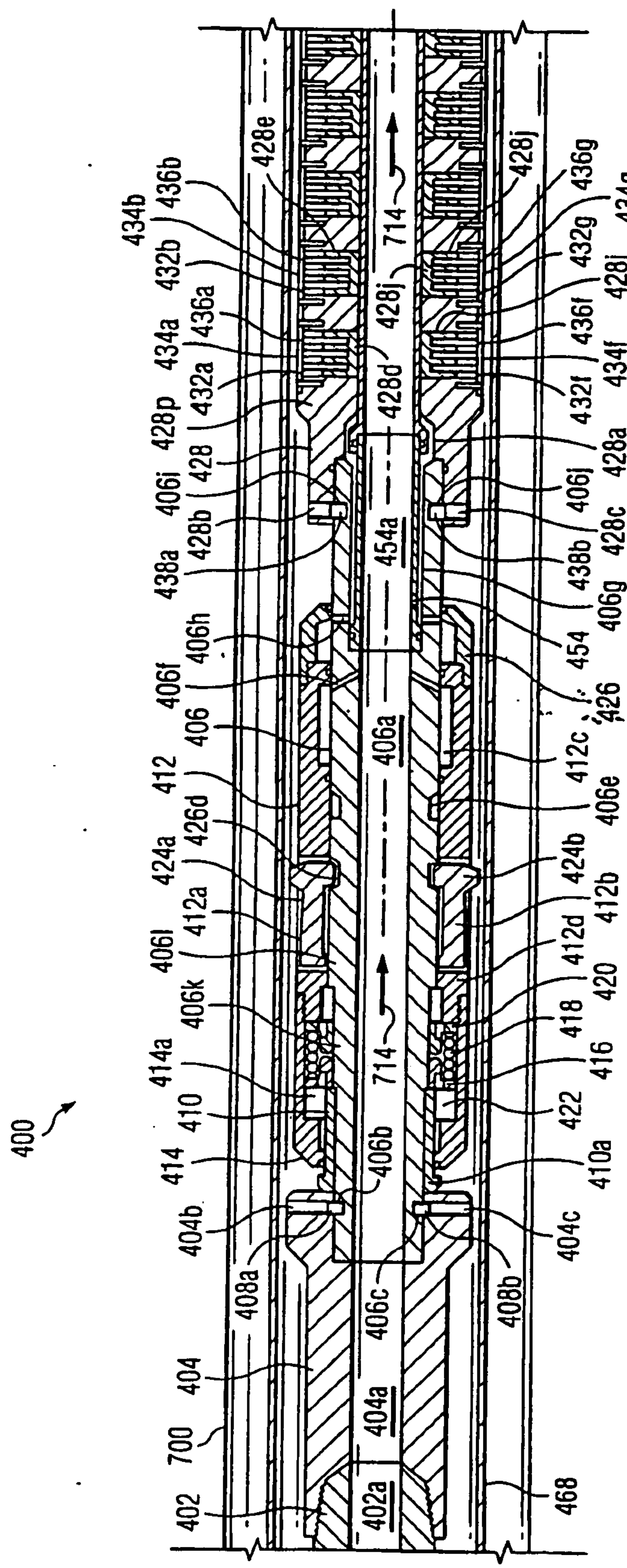

700
654
654b
654a
654c
656
656
650a
646a
650
648a
704
646
644
648
644a
400
638a
638b
644c
644b
638
470
712

Fig. 32k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402
402a
404
404a
404b
404c
406
406a
406b
406c
406e
406f
406g
406h
406i
406j
406k
406l
408a
408b
410
410a
412
412a
412b
412c
412d
414
414a
416
418
420
422
424a
424b
426
426d
428
428a
428b
428c
428d
428e
428i
428j
428p
432a
432b
432f
432g
434a
434b
434f
434g
436a
436b
436f
436g
438a
438b
454
454a
468
700
714

Fig. 33a

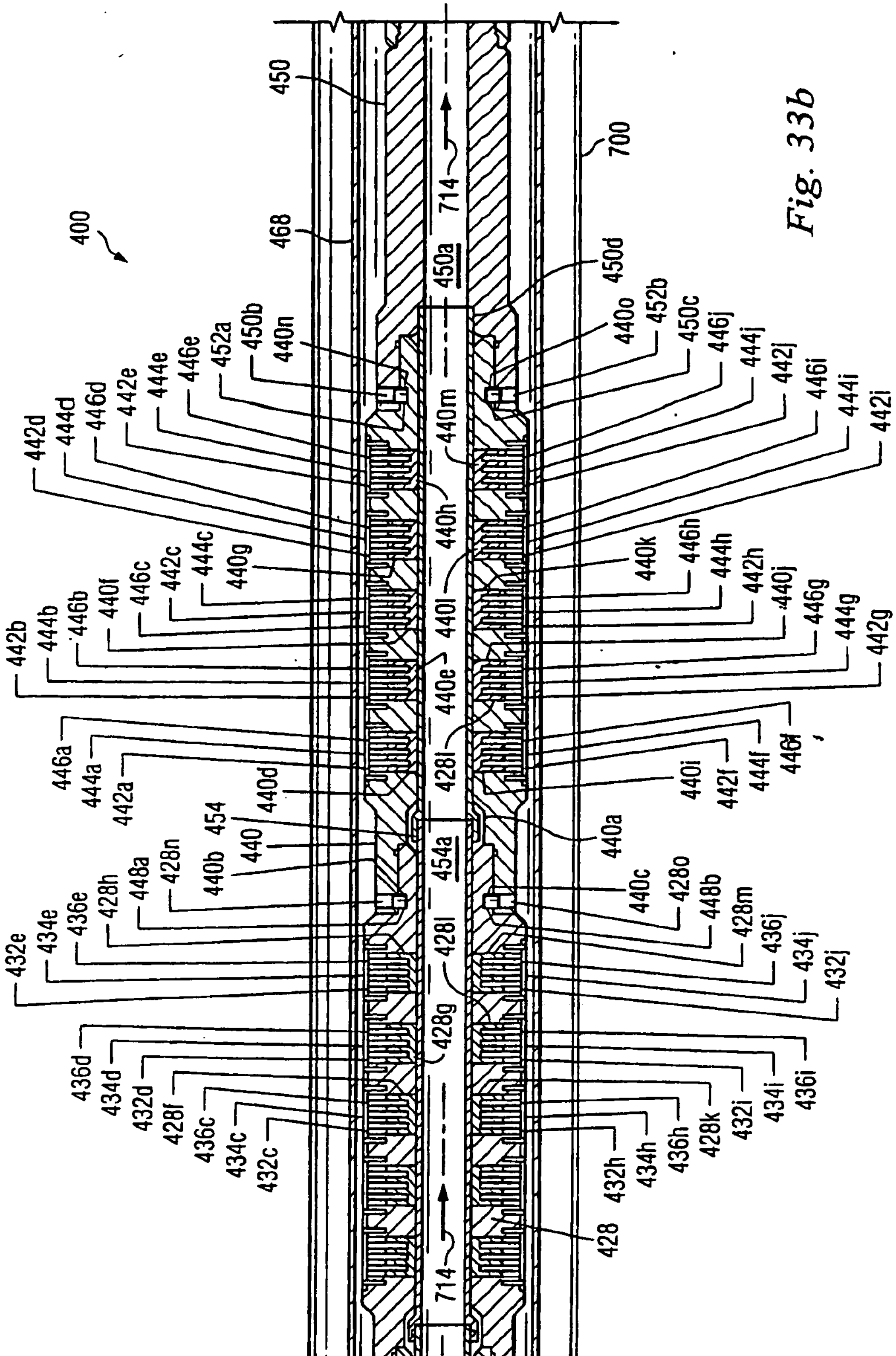

400
468
450
714
450a
700
450d
440o
452b
450c
446j
444j
442j
446i
444i
442i
440n
450b
452a
446e
444e
442e
446d
444d
442d
440m
440h
440g
444c
442c
446c
440f
446b
444b
442b
440k
446h
444h
442h
440j
446g
444g
442g
440l
440e
428i
446a
444a
442a
440d
454
440
440b
428n
448a
428h
436e
434e
432e
440i
442f
444f
446f
440a
454a
440c
428o
448b
428m
436j
434j
432j
428l
428g
436d
434d
432d
428f
436c
434c
432c
436i
434i
432i
428k
436h
434h
432h
428
714

Fig. 33b

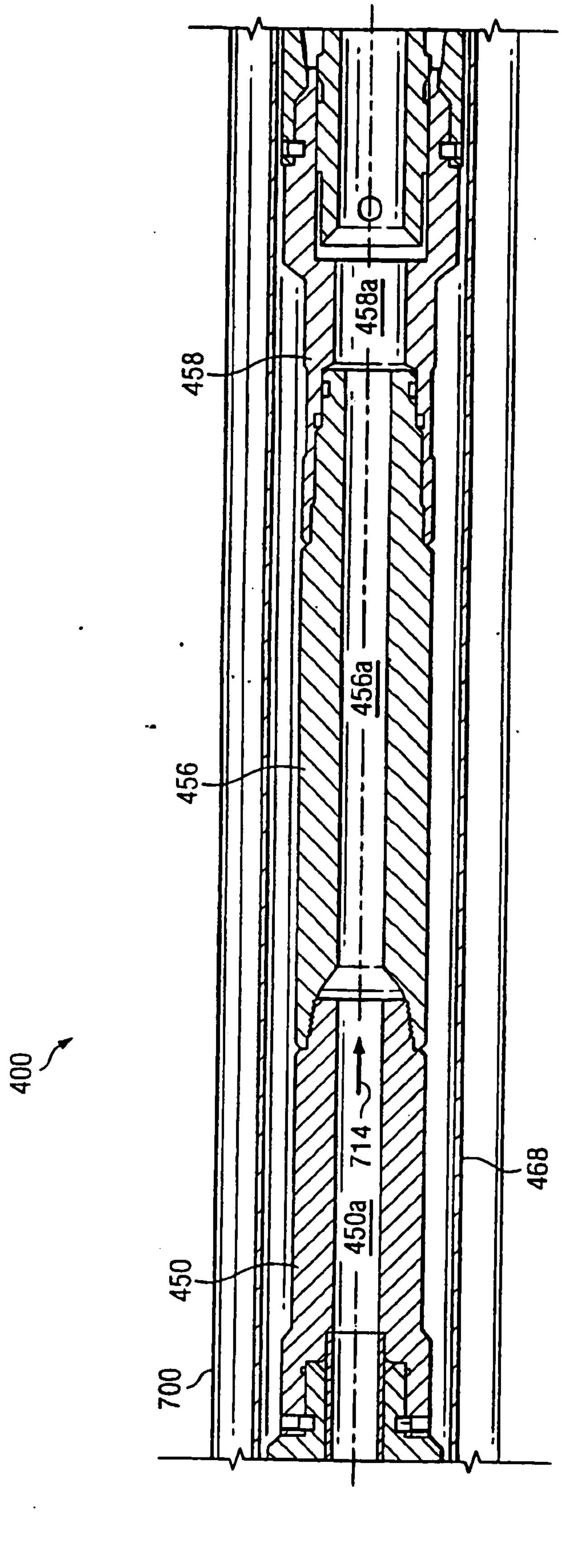


Fig. 33c

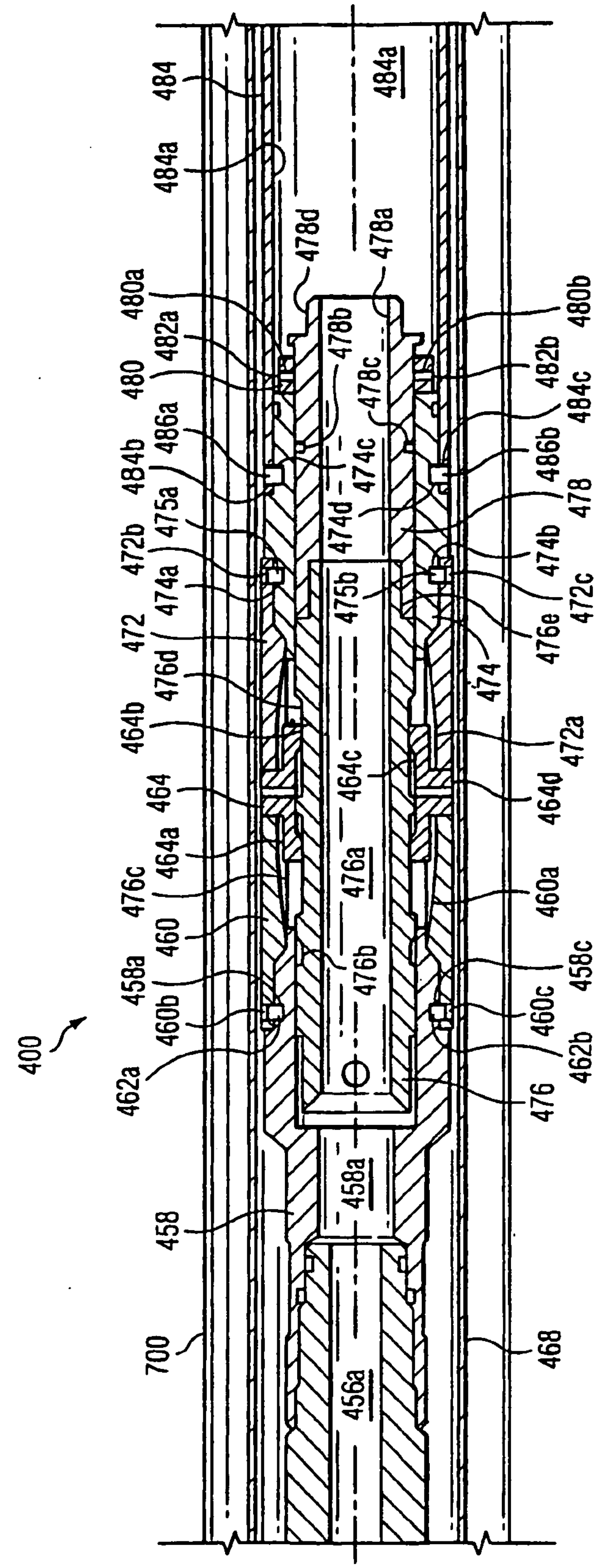
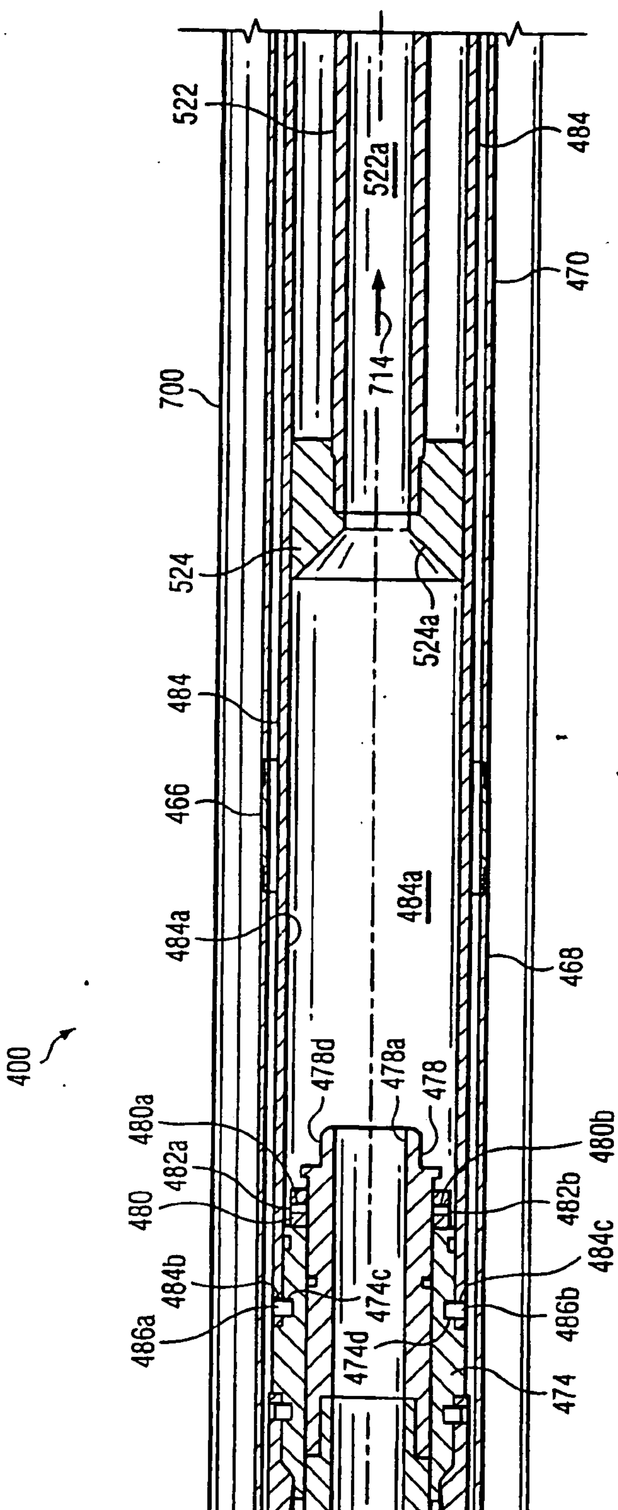
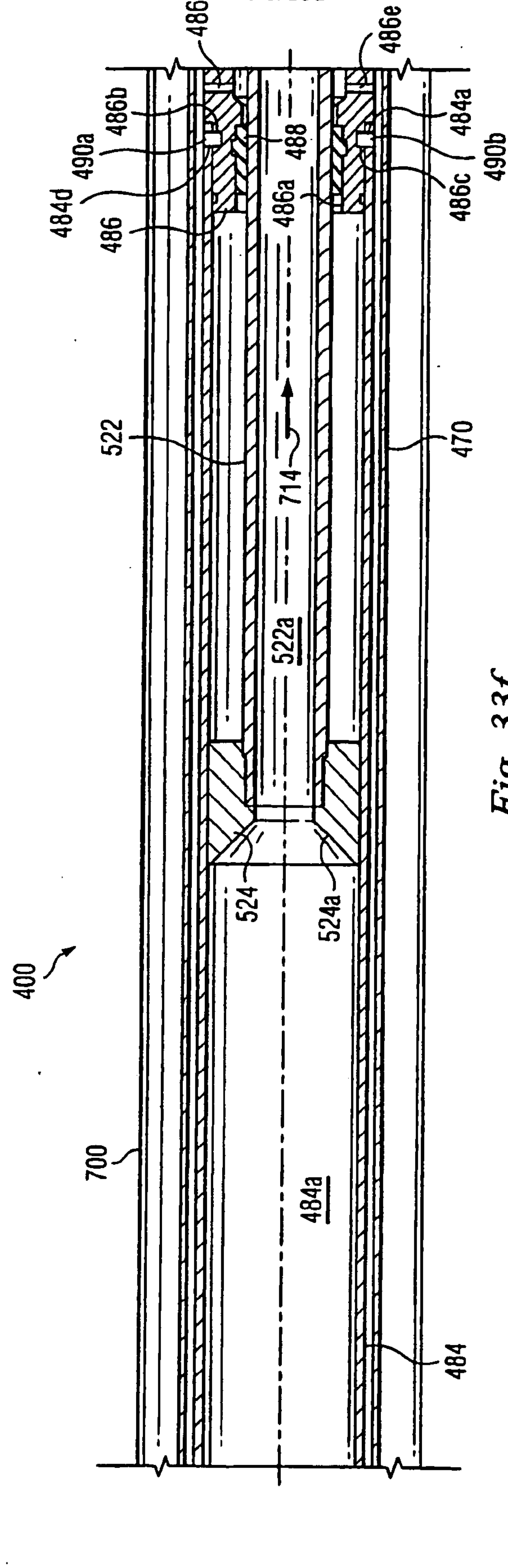

484
484a
478d
478a
480a
482a
480
486a
484b
475a
472b
474a
472
476d
464b
464
464a
476c
460
458a
460b
462a
400
458
700
478b
478c
474c
474d
475b
464c
476a
476b
458a
456a
480b
482b
484c
486b
478
474b
472c
476e
474
472a
464d
460a
458c
460c
462b
476
468

Fig. 33d



522
522a
484
470
714
700
524
524a
484
466
484a
484a
468
400
478d
478a
478
480a
482a
480
484b
486a
474c
474d
480b
482b
484c
486b
474

Fig. 33e



486d
486e
486b
484a
490a
488
490b
484d
486c
486
486a
522
714
470
522a
524
524a
400
700
484a
484

Fig. 33f

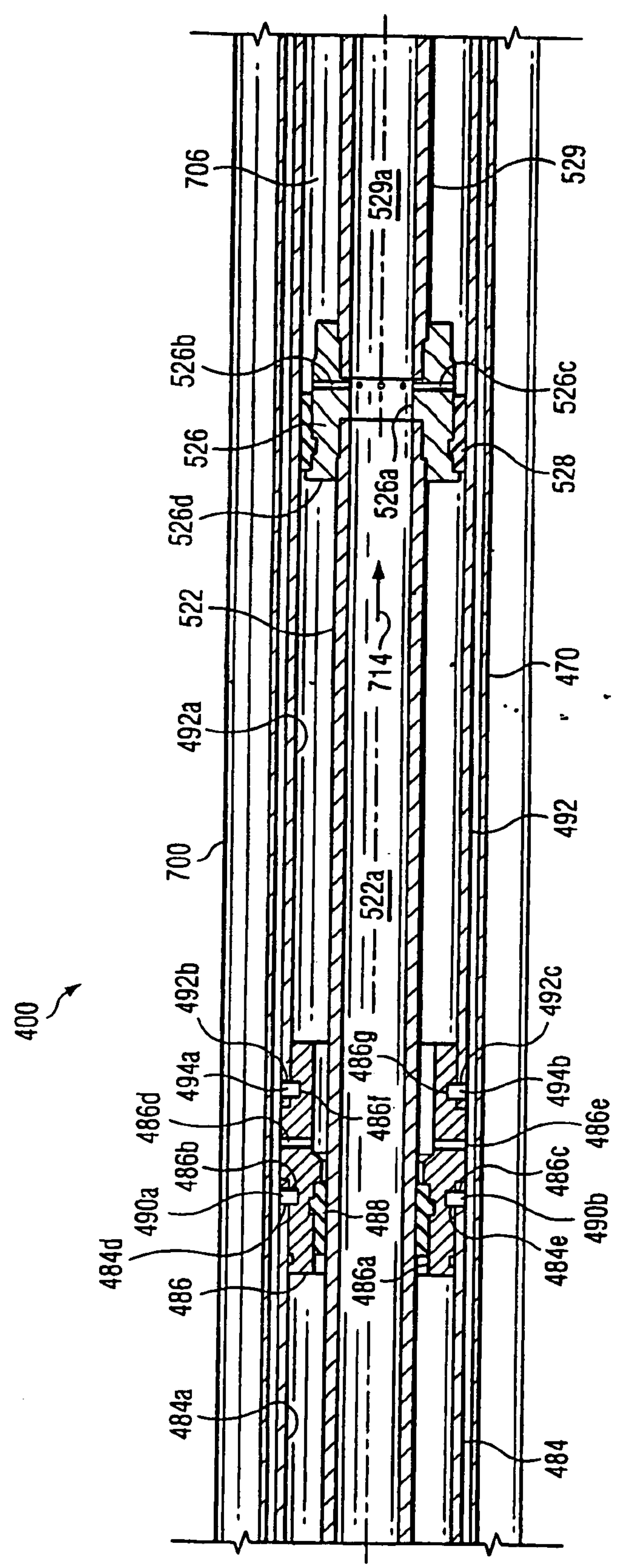

706
529a
529
526b
526c
526
528
526a
526d
522
714
470
492a
492
700
522a
400
492b
492c
486g
494a
494b
486f
486d
486e
486b
486c
490a
488
490b
484d
484e
486a
486
484a
484

Fig. 33g

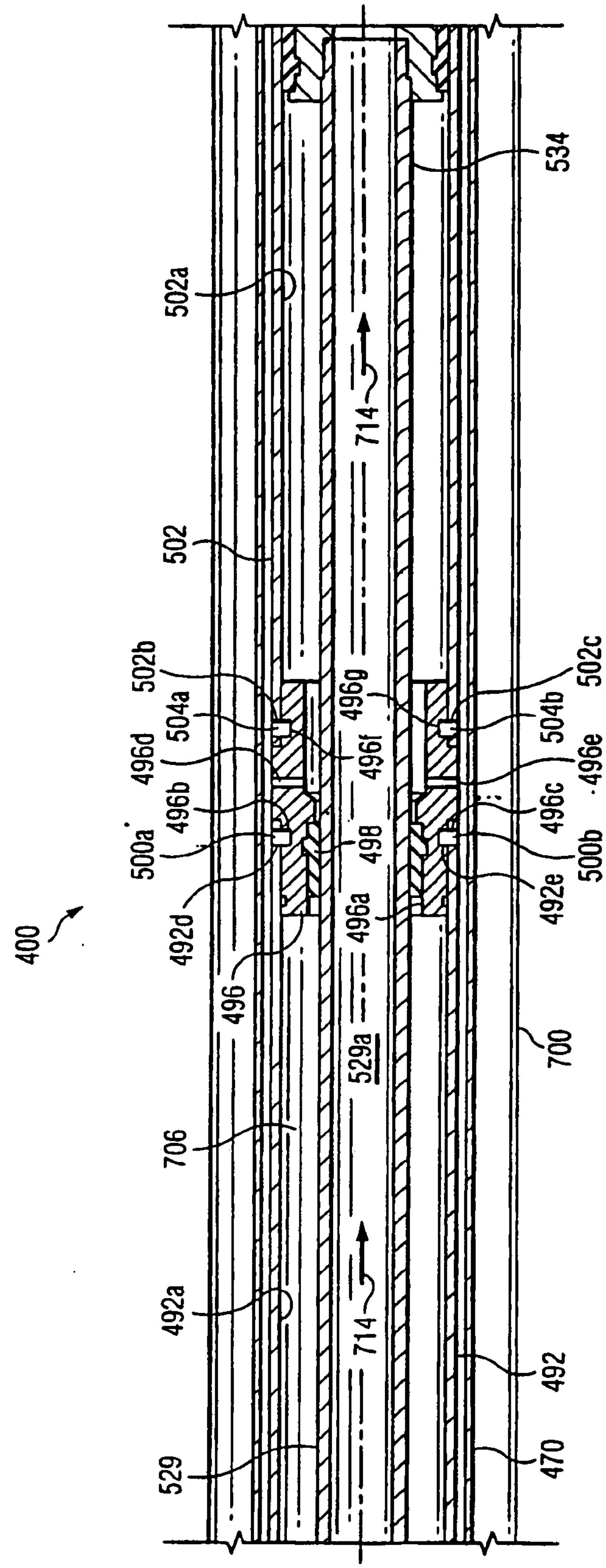

400
502a
502
502b
504a
496d
496b
500a
492d
496
706
492a
529
714
496g
496f
498
496a
529a
534
502c
504b
496e
496c
500b
492e
700
492
470

Fig. 33h

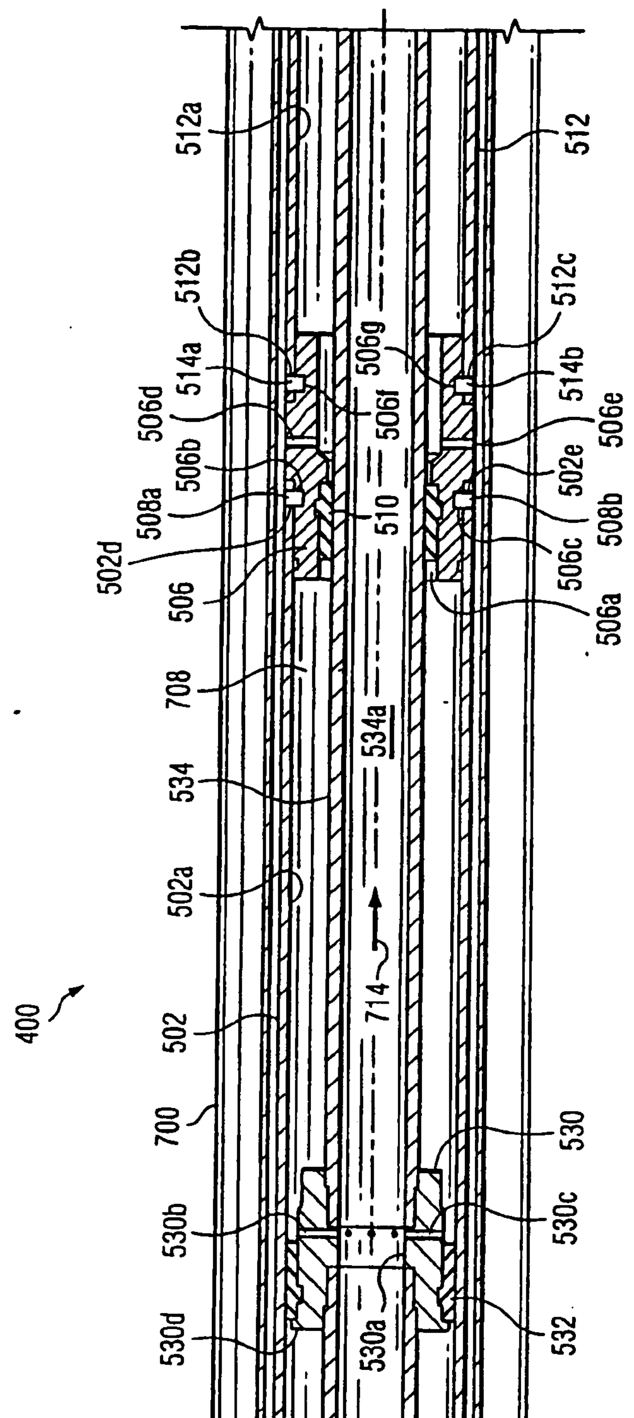
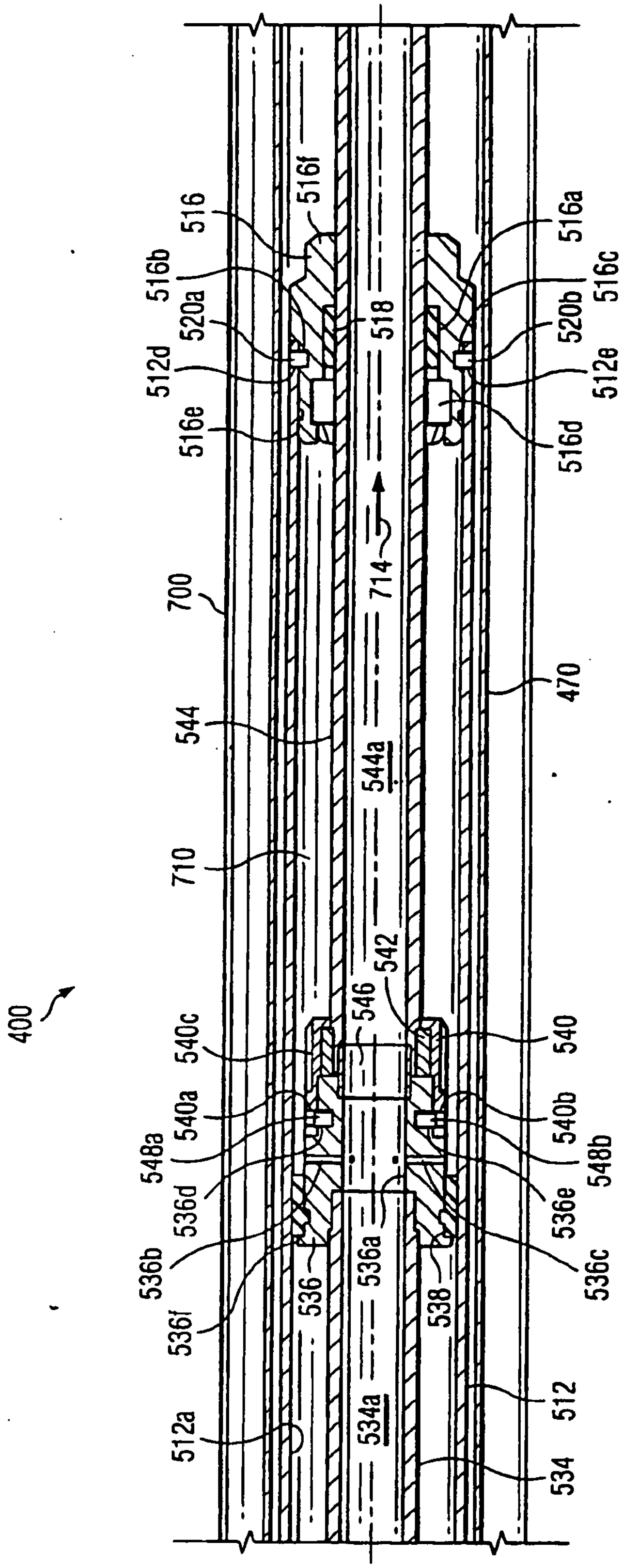

512a
512
512b
512c
514a
506g
514b
506d
506f
506e
506b
502e
508a
510
508b
502d
506c
506
506a
708
534a
534
502a
400
714
502
700
530
530b
530c
530d
530a
532
529a
529
470

Fig. 33i



516
516b
516f
520a
512d
516e
518
516a
516c
520b
512e
516d
714
700
544
544a
710
470
400
546
542
540c
540
540a
540b
548a
536d
536e
548b
536b
536a
536
538
536c
536f
512a
534a
512
534

Fig. 33j

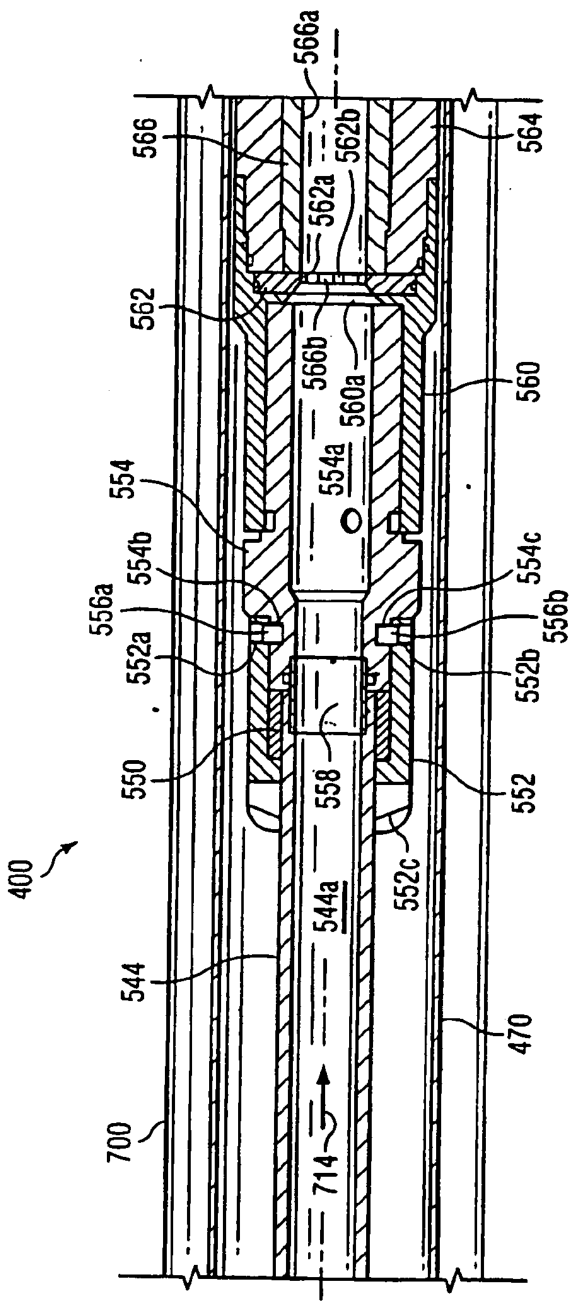
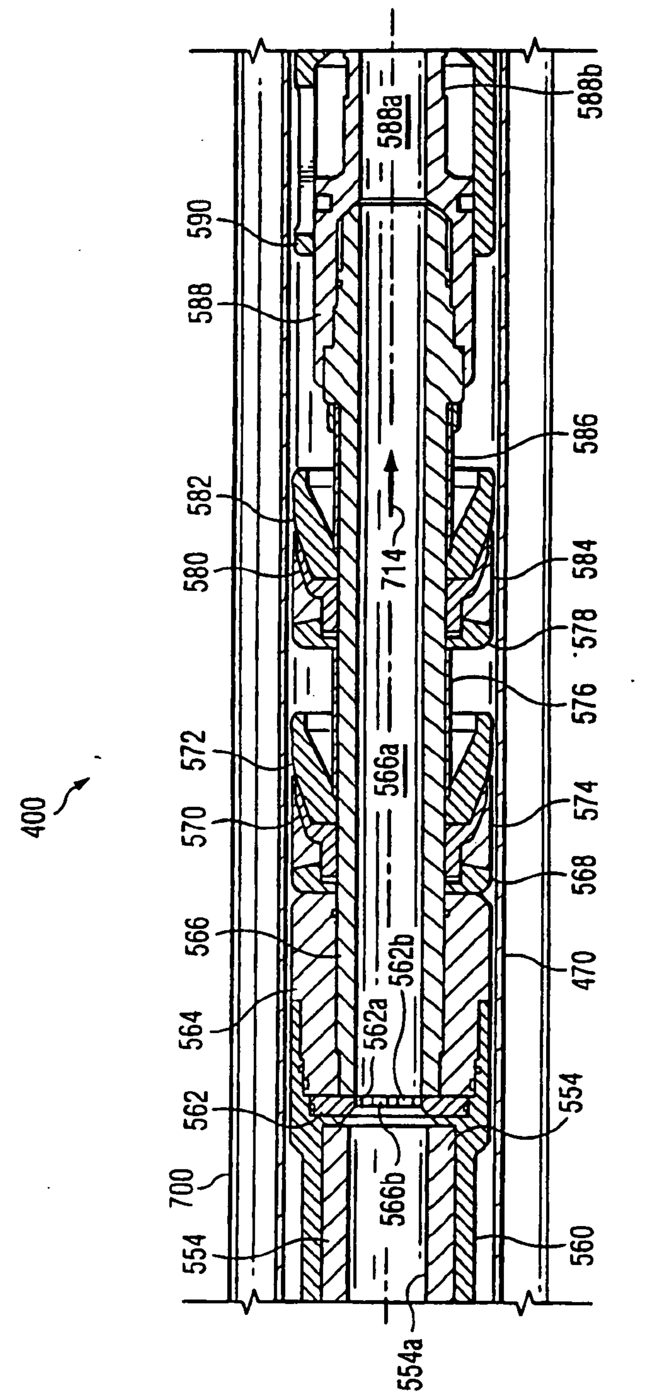

566a
566
562b
562a
564
562
566b
560a
560
554
554a
554b
554c
556a
556b
552a
552b
550
558
552
552c
400
544a
544
470
700
714

Fig. 33k



400
590
588
582
580
572
570
566
564
562
700
554
554a
566b
562a
562b
566a
714
588a
588b
586
584
578
576
574
568
470
554
560

Fig. 331

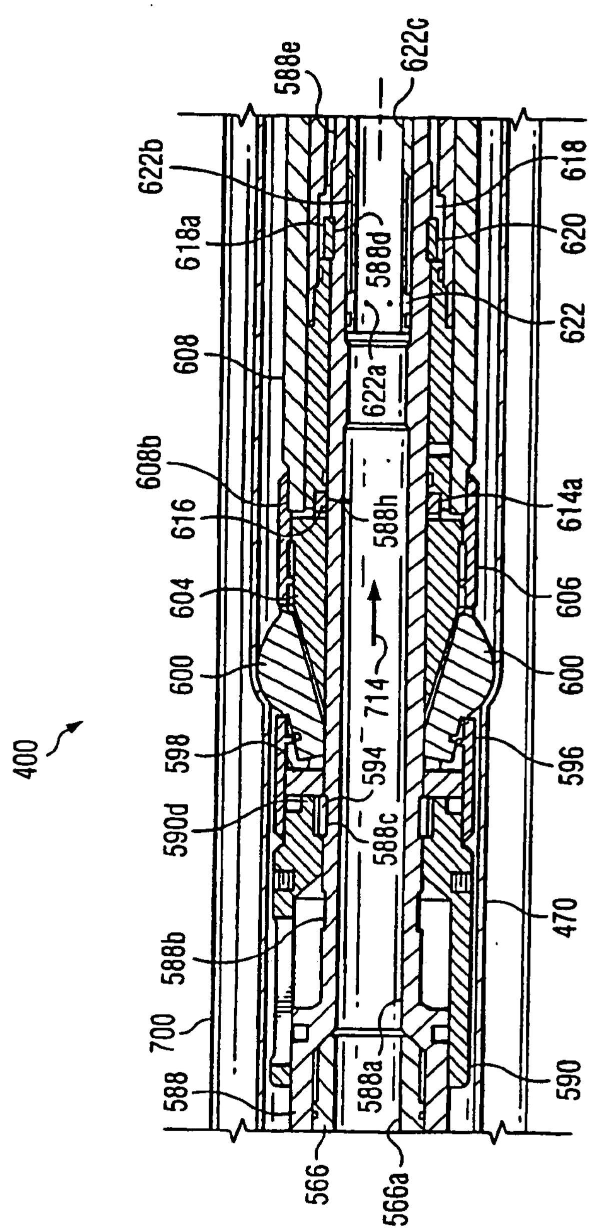

400
588
700
588b
590d
598
600
604
616
608b
608
618a
622b
588e
622c
618
620
622
614a
606
600
596
470
590
566
566a
588a
588c
594
714
588h
622a
588d

Fig. 33m

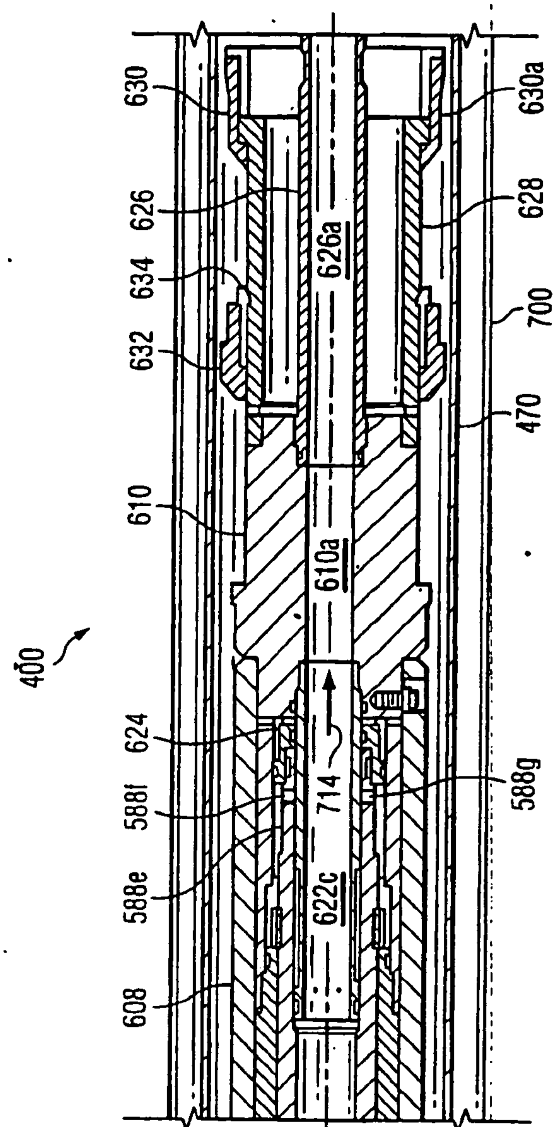

630
626
634
632
610
400
624
588f
588e
608
626a
610a
714
622c
630a
628
700
470
588g

Fig. 33n

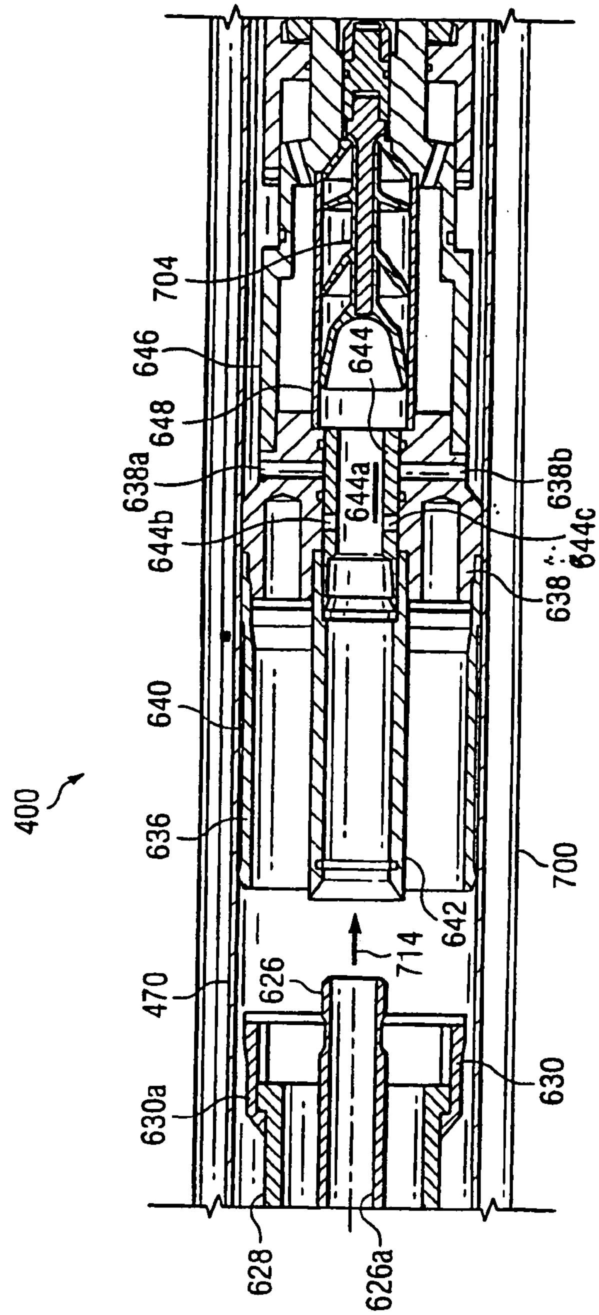

704
646
648
638a
644b
640
636
400
470
630a
628
626a
626
714
642
700
630
638
644c
638b
644a
644

Fig. 33o

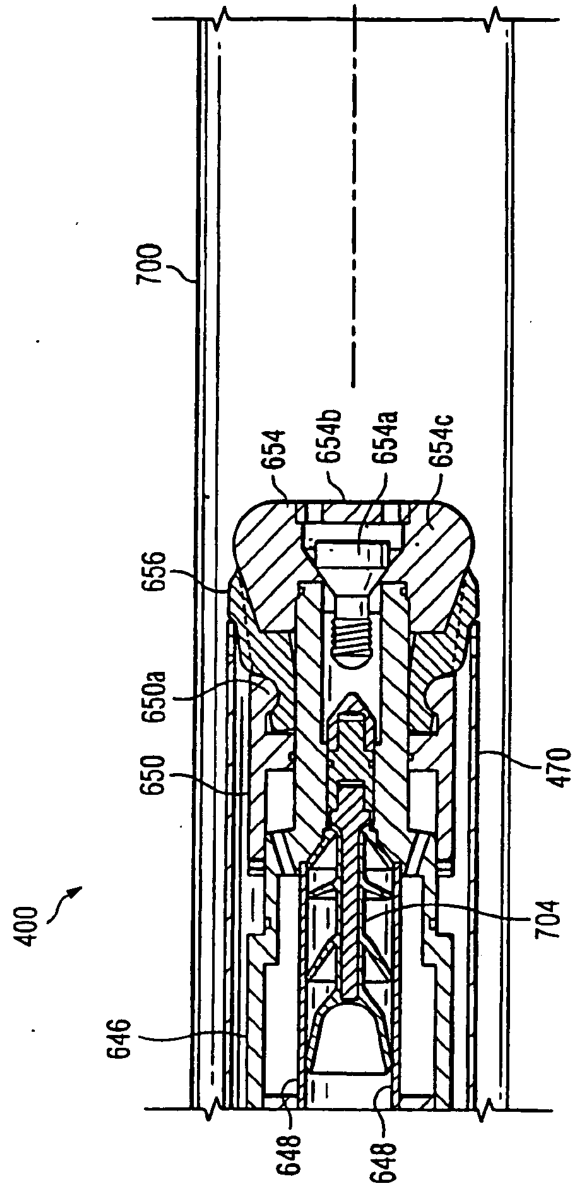
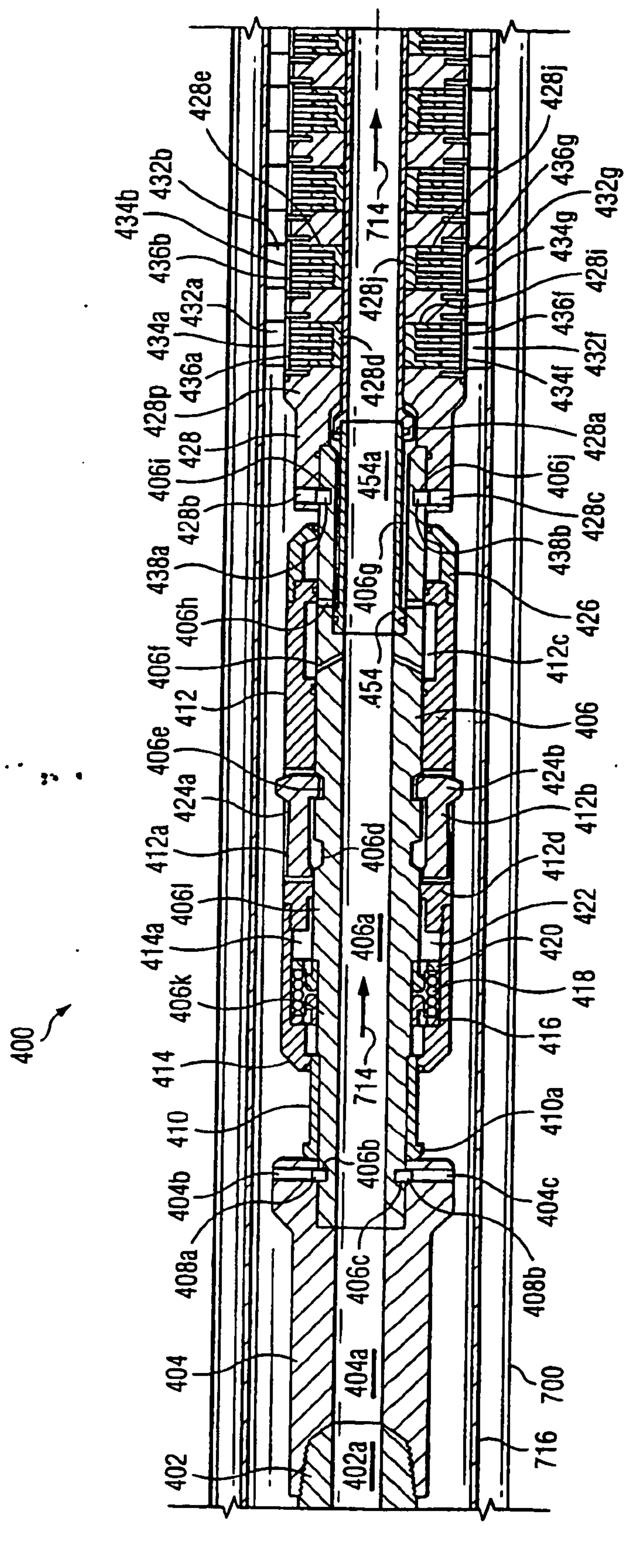


Fig. 33p



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402
402a
404
404a
404b
404c
406
406a
406b
406c
406d
406e
406f
406g
406h
406i
406j
406k
406l
408a
408b
410
410a
412
412a
412b
412c
412d
414
414a
416
418
420
422
424a
424b
426
428
428a
428b
428c
428d
428e
428i
428j
428p
432a
432b
432f
432g
434a
434b
434f
434g
436a
436b
436f
436g
438a
438b
454
454a
700
714
716

Fig. 34a

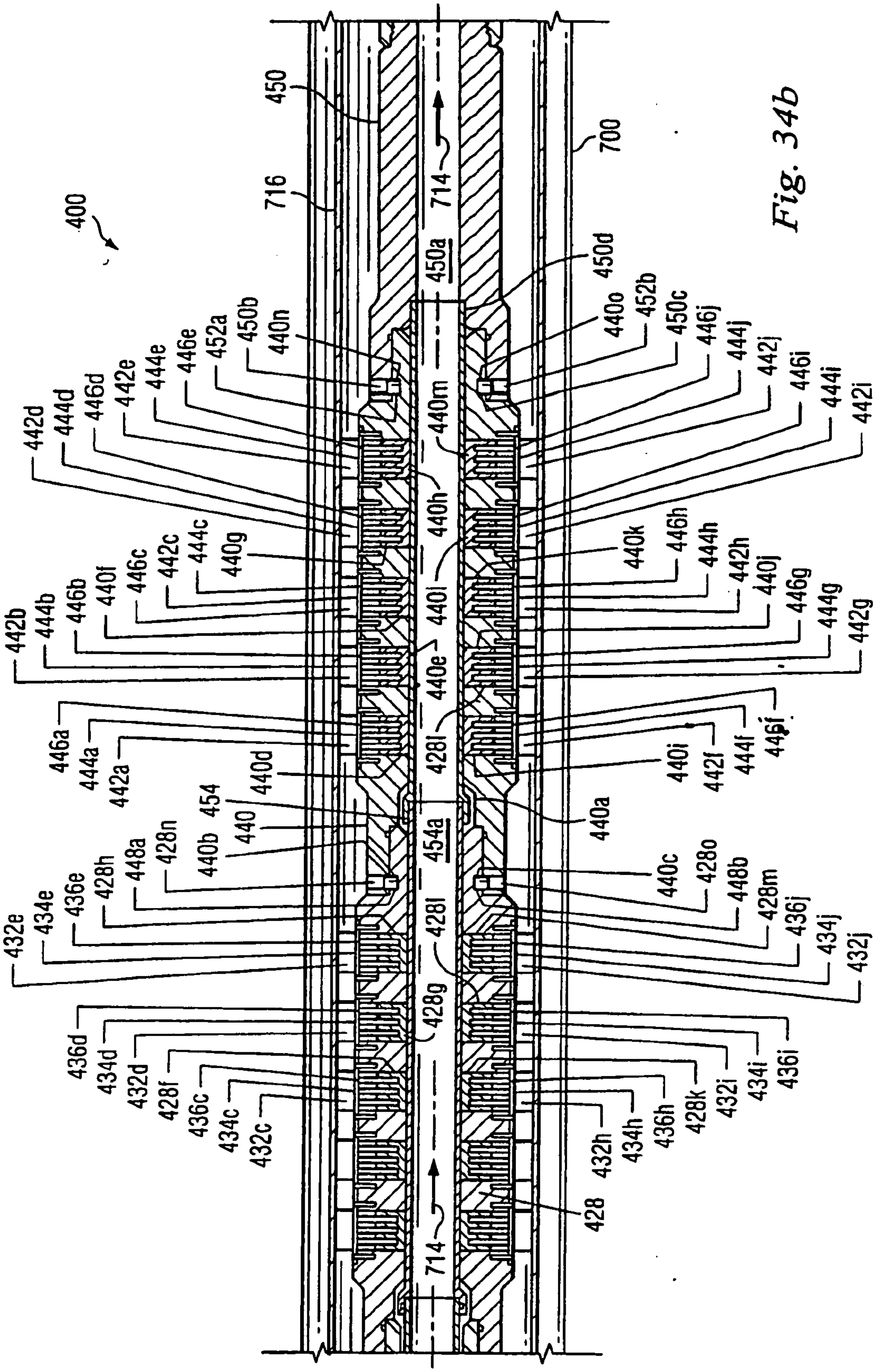

400
716
450
714
700
450a
450d
450b
440n
452a
446e
444e
442e
446d
444d
442d
440o
452b
450c
446j
444j
442j
446i
444i
442i
440m
440h
440k
446h
444h
442h
440j
446g
444g
442g
440g
444c
442c
446c
440f
446b
444b
442b
440l
440e
428l
446a
444a
442a
440d
454
440
440b
428n
448a
428h
436e
434e
432e
454a
440a
440c
428o
448b
428m
436j
434j
432j
428i
428g
436d
434d
432d
428f
436c
434c
432c
446f
444f
442f
440i
436i
434i
432i
428k
436h
434h
432h
428
714

Fig. 34b

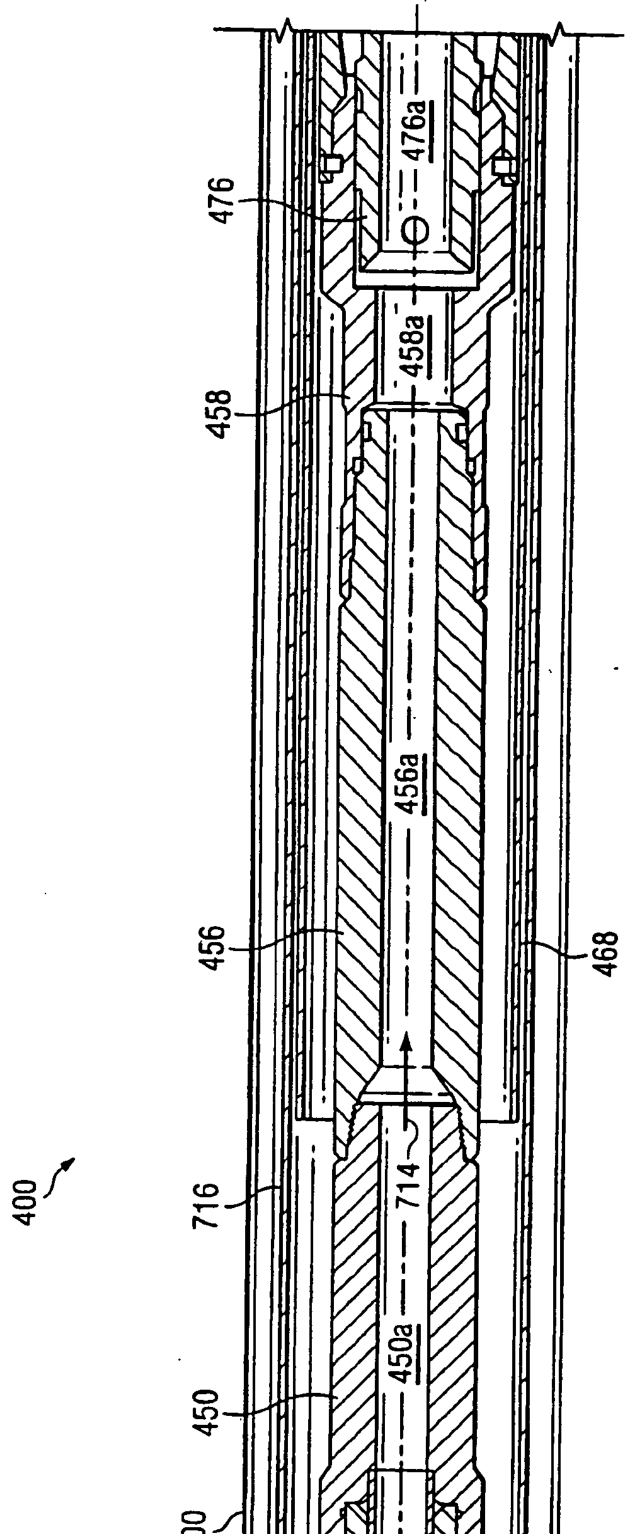
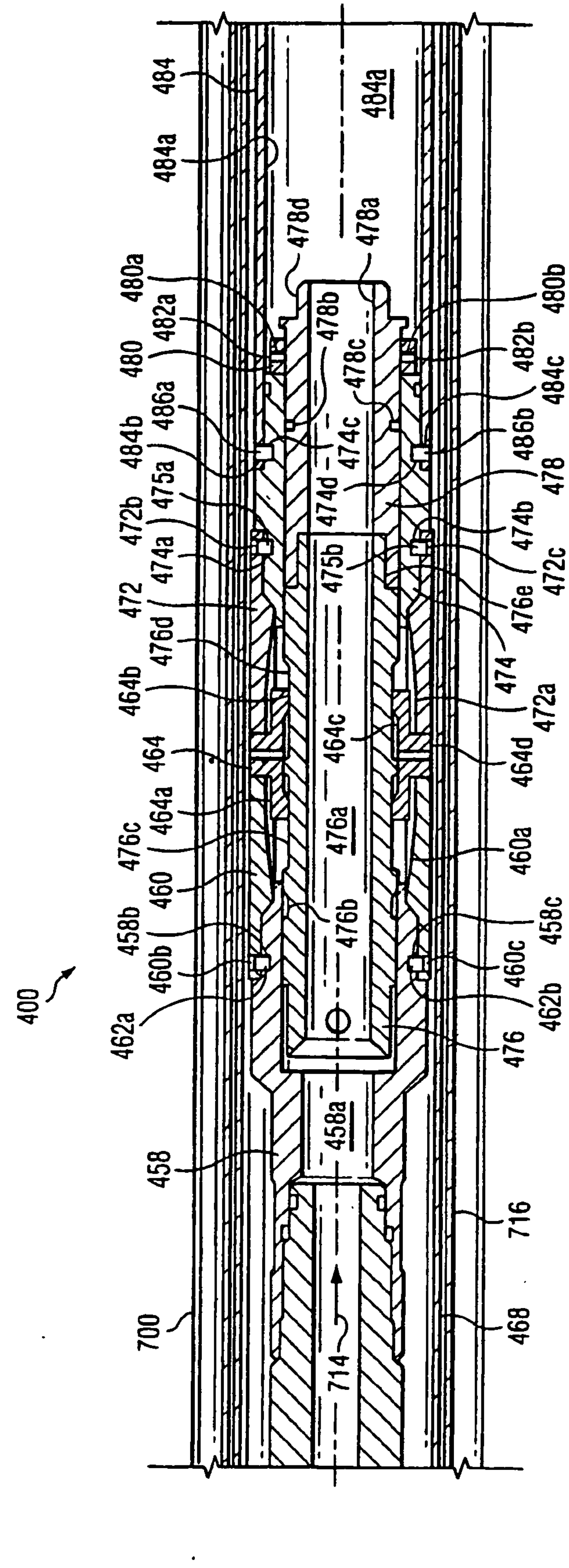


Fig. 34c



400
484
484a
484a
478d
478a
480a
482a
480
478b
478c
480b
482b
484c
486a
484b
474c
486b
474d
478
475a
472b
474b
474a
475b
472c
472
476e
476d
474
464b
472a
464c
464
464d
464a
476a
476c
460a
460
476b
458b
458c
460b
460c
462a
462b
476
458a
458
716
700
714
468

Fig. 34d

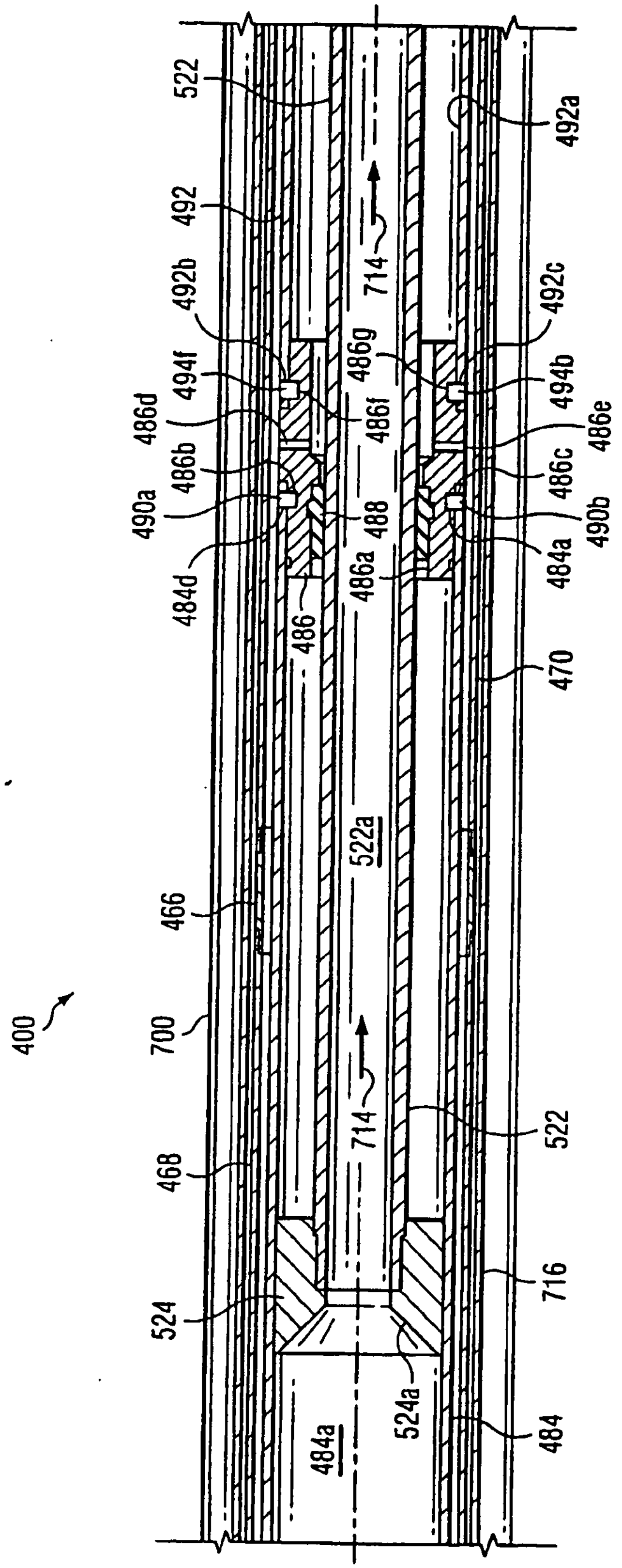
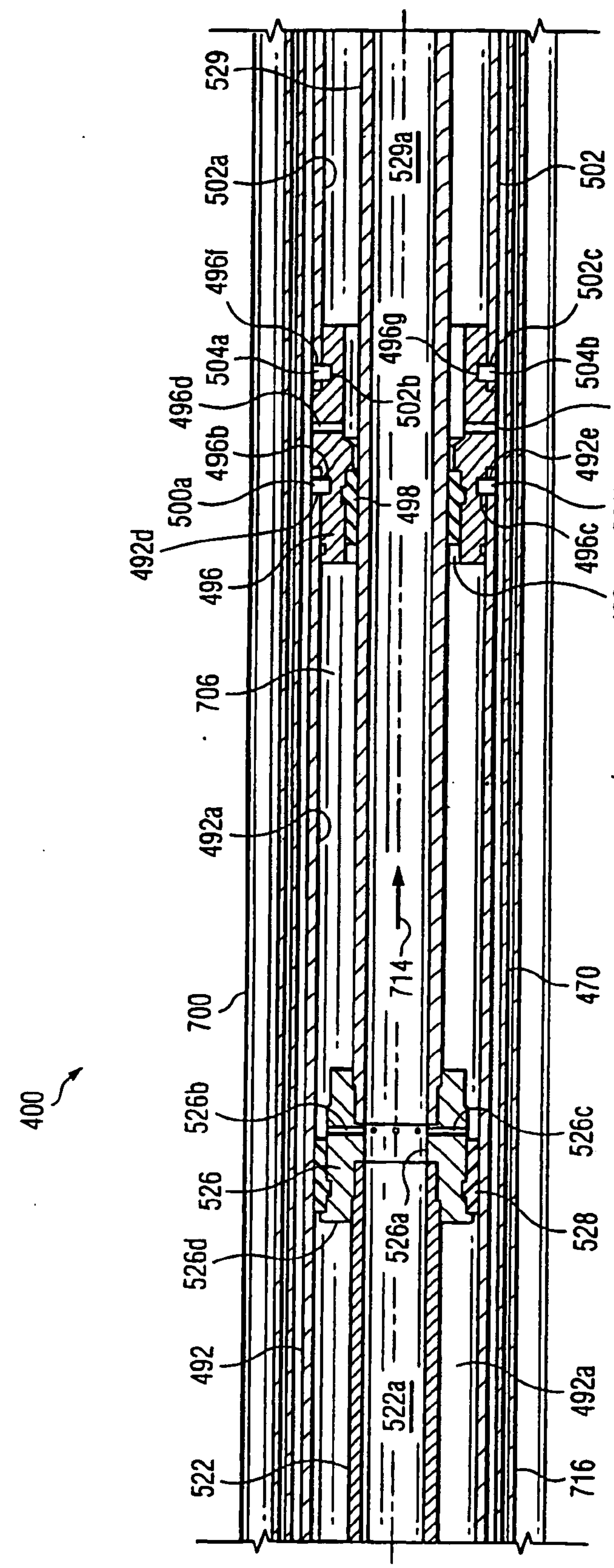

522
492a
492
714
492b
492c
486g
494f
494b
486d
486f
486e
486b
486c
490a
488
490b
484d
486a
484a
486
470
522a
466
400
700
714
522
468
716
524
524a
484a
484

Fig. 34e



400
529
529a
502a
502
496f
502c
496g
504a
504b
496d
502b
496e
496b
492e
500a
498
500b
492d
496c
496
496a
706
492a
714
700
470
526b
526c
526
526a
528
526d
492
522a
492a
522
716

Fig. 34f

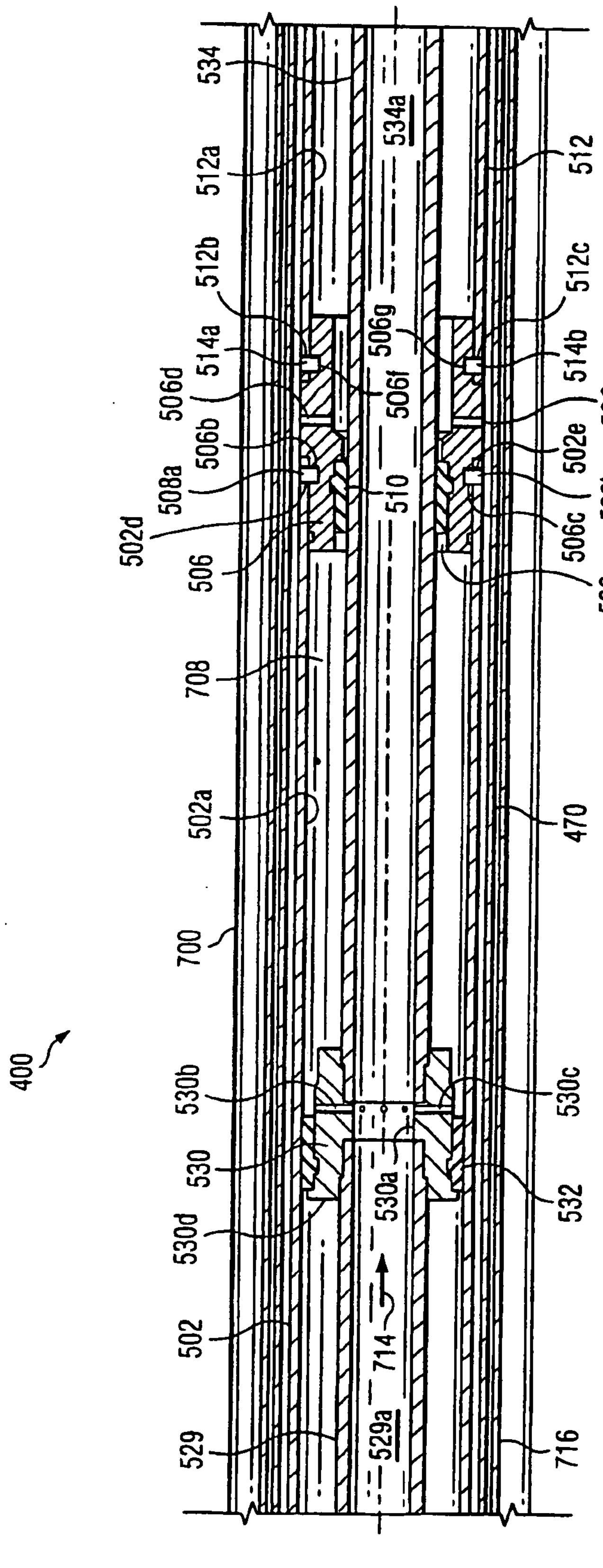

534
534a
512a
512
512b
512c
506g
514a
514b
506d
506f
506e
506b
502e
508a
510
508b
502d
506c
506
506a
708
502a
470
700
400
530b
530c
530
530a
532
530d
502
714
529
529a
716

Fig. 34g

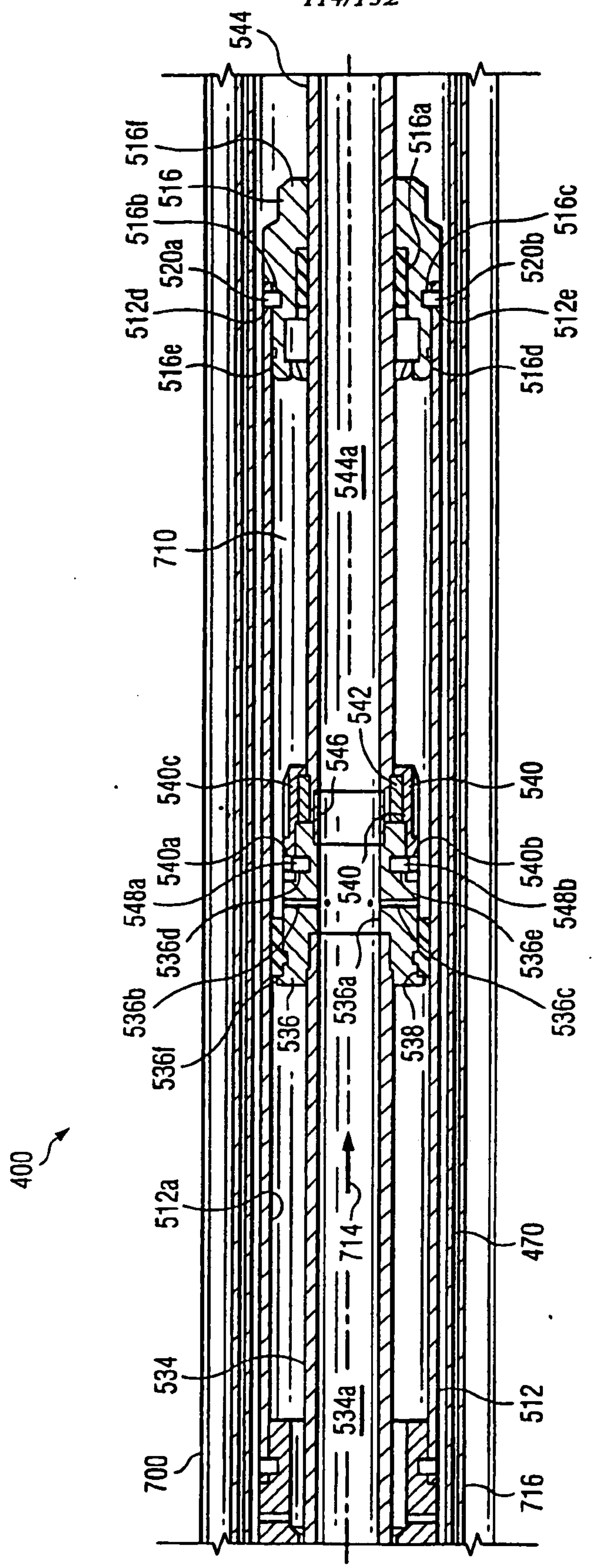

544
516f
516
516b
520a
512d
516e
516a
516c
520b
512e
516d
544a
710
546
542
540c
540
540a
540b
548a
548b
536d
536e
536b
536f
536
536a
538
536c
400
512a
714
470
534
534a
512
700
716

Fig. 34h

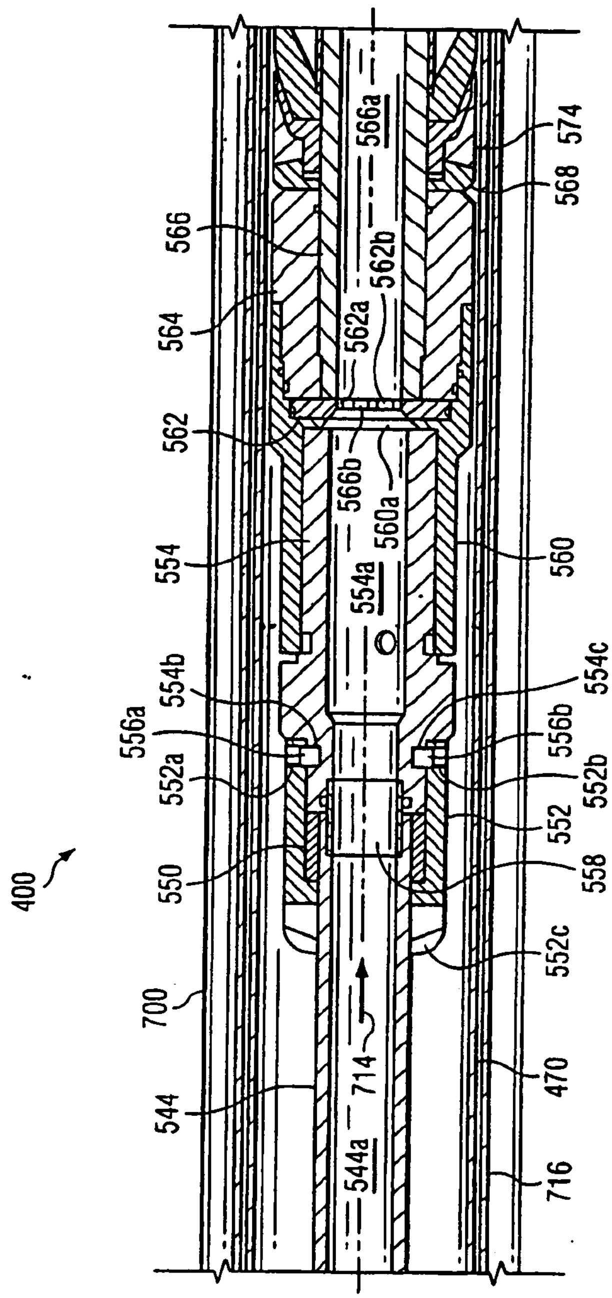

400
566a
574
568
566
562b
564
562a
562
566b
560a
554
554a
560
554b
554c
556a
556b
552a
552b
552
550
558
552c
700
714
544
470
544a
716

Fig. 34i

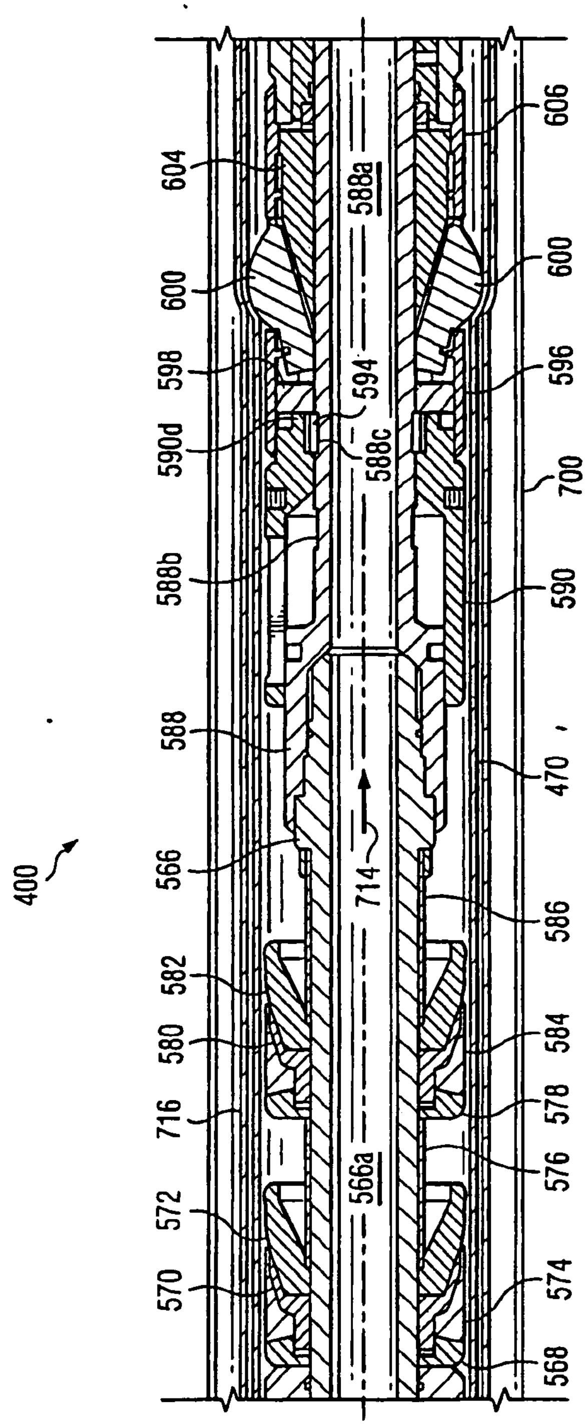

400
604
600
598
590d
588b
588
566
582
580
716
572
570
588a
594
588c
714
566a
606
600
596
700
590
470
586
584
578
576
574
568

Fig. 34j

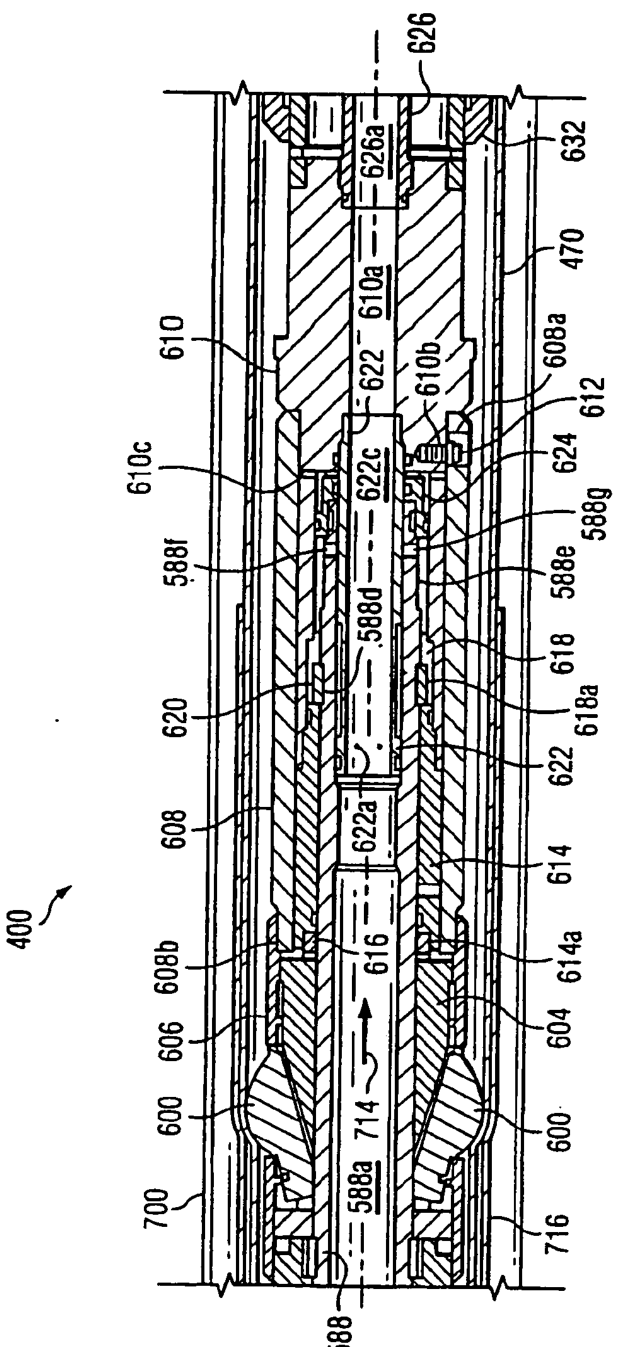
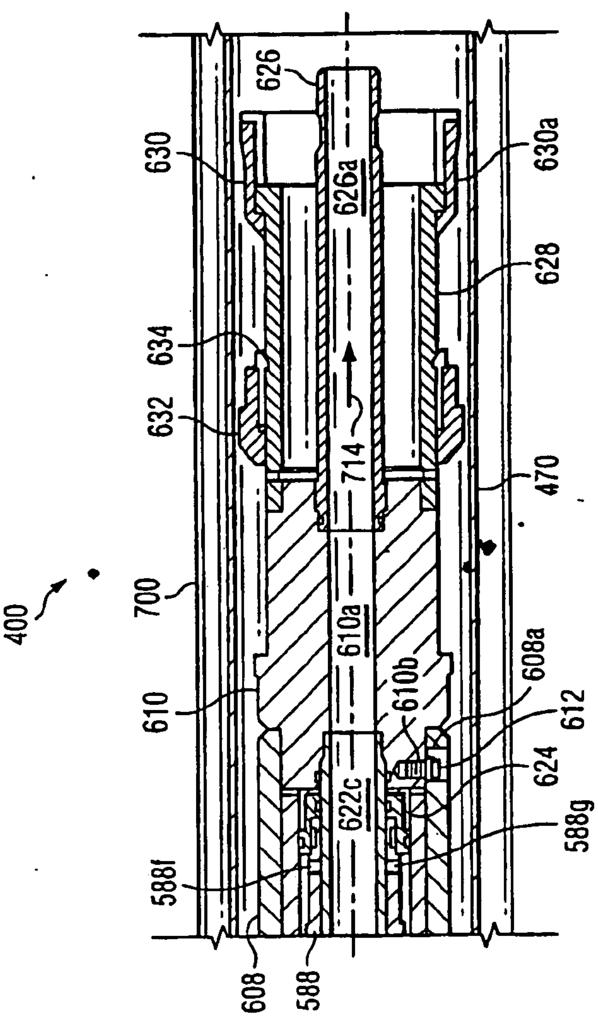

400
626
626a
632
470
610
610a
622
610b
608a
612
610c
622c
624
588g
588f
588e
588d
618
620
618a
622
608
622a
614
608b
616
614a
606
604
714
600
600
700
588a
716
588

Fig. 34k


400
700
610
588f
608
588
630
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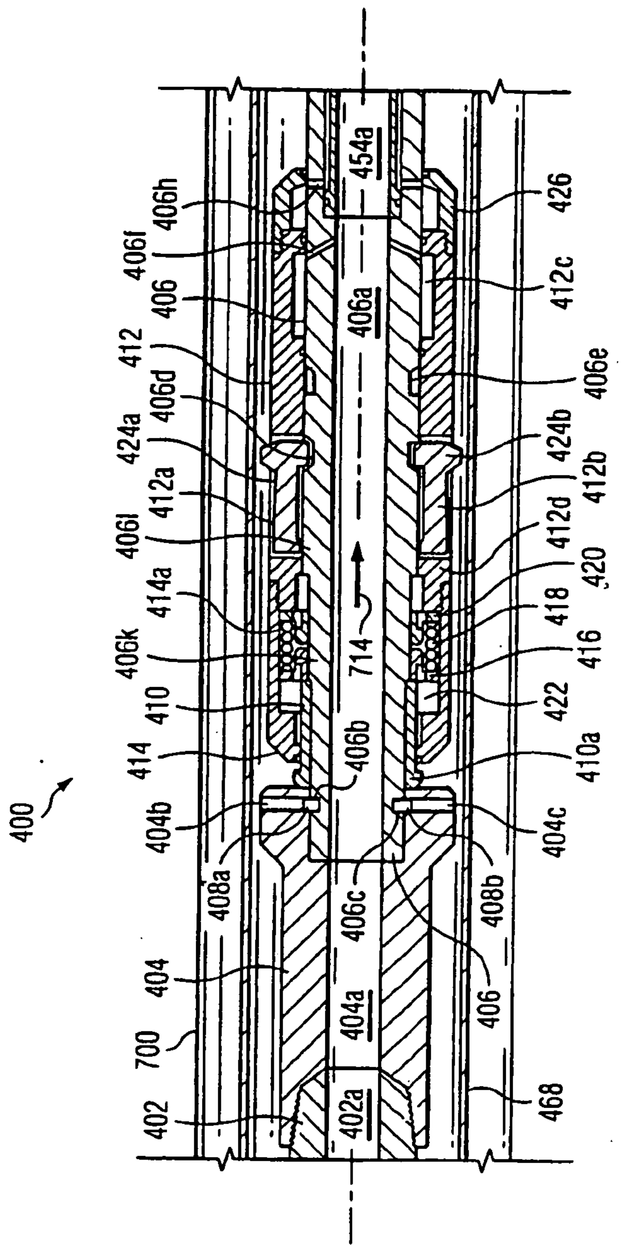
632
626
626a
714
610a
610b
622c
630a
628
470
608a
612
624
588g

Fig. 34l


400
402
402a
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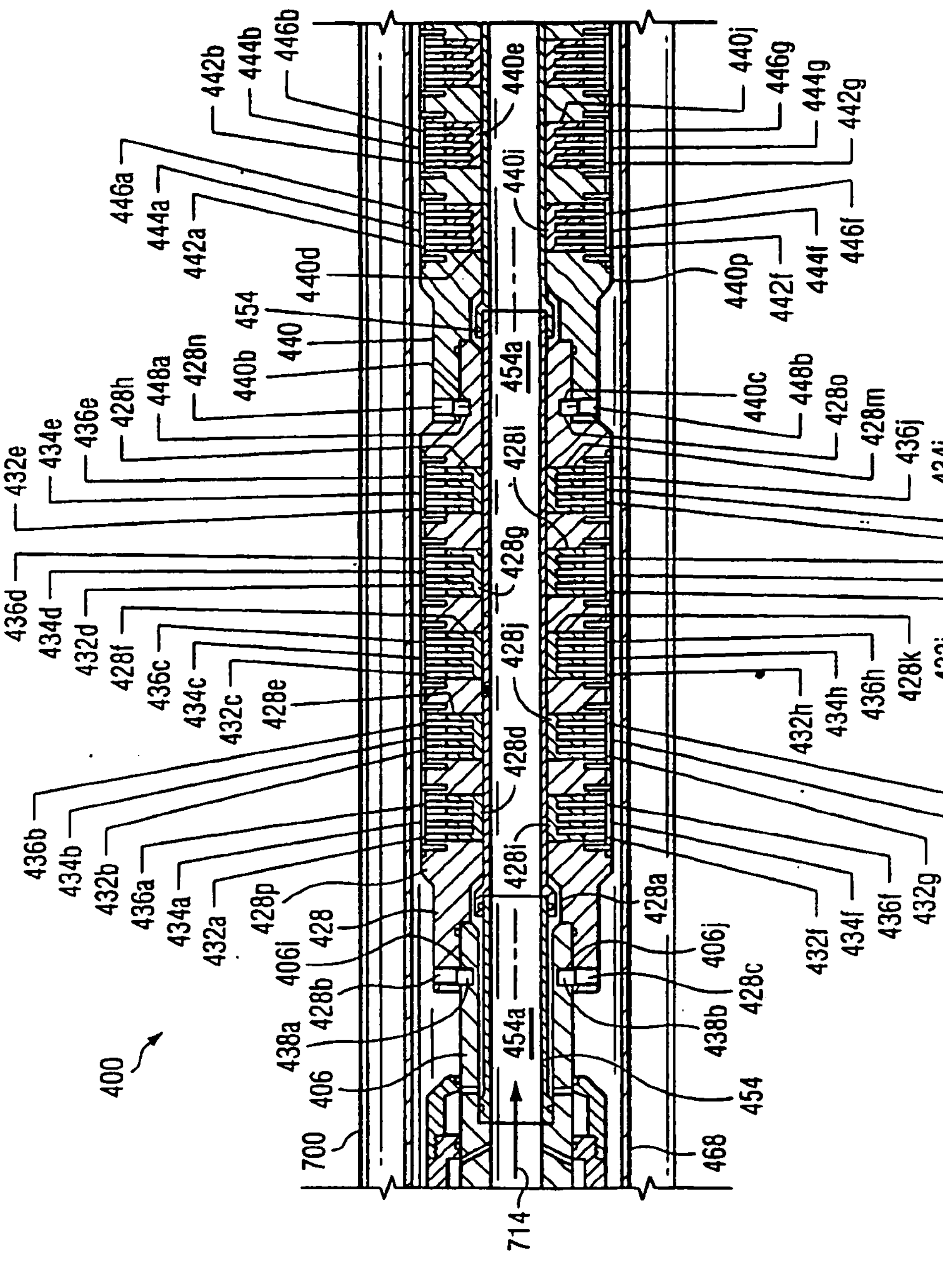
404a
404b
404c
406
406a
406b
406c
406d
406e
406f
406h
406k
406l
408a
408b
410
410a
412
412a
412b
412c
412d
414
414a
416
418
420
422
424a
424b
426
454a
468
700
714

Fig. 35a


400
700
406
438a
428b
406i
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428p
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432b
434b
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436c
428f
432d
434d
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432e
434e
436e
428h
448a
428n
440b
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454
440d
442a
444a
446a
442b
444b
446b
440e
440i
454a
428l
428g
428j
428d
428i
714
468
454
438b
428c
406j
428a
432f
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436f
432g
434g
436g
432h
434h
436h
428k
432i
434i
436i
432j
434j
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428o
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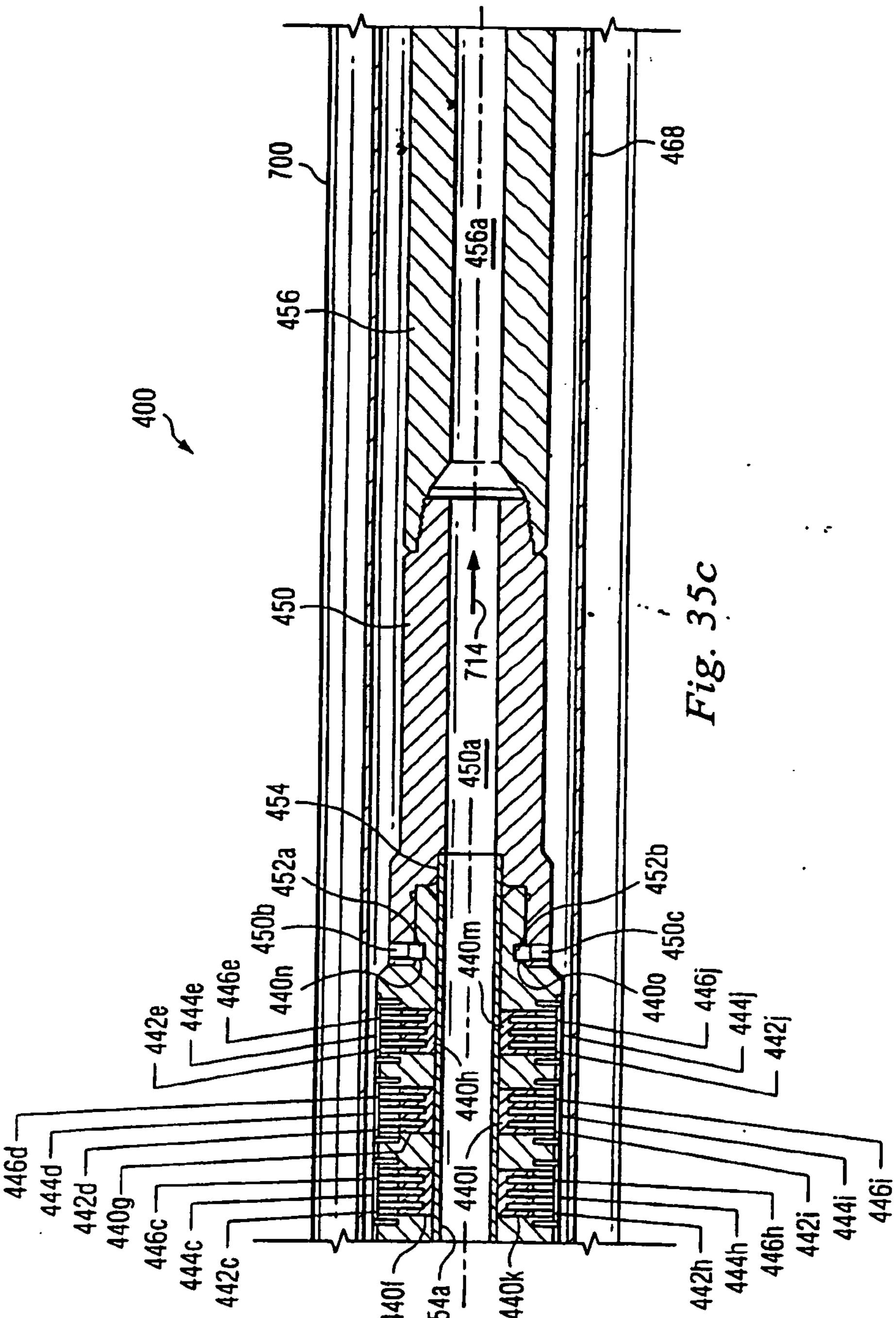
Fig. 35b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444d
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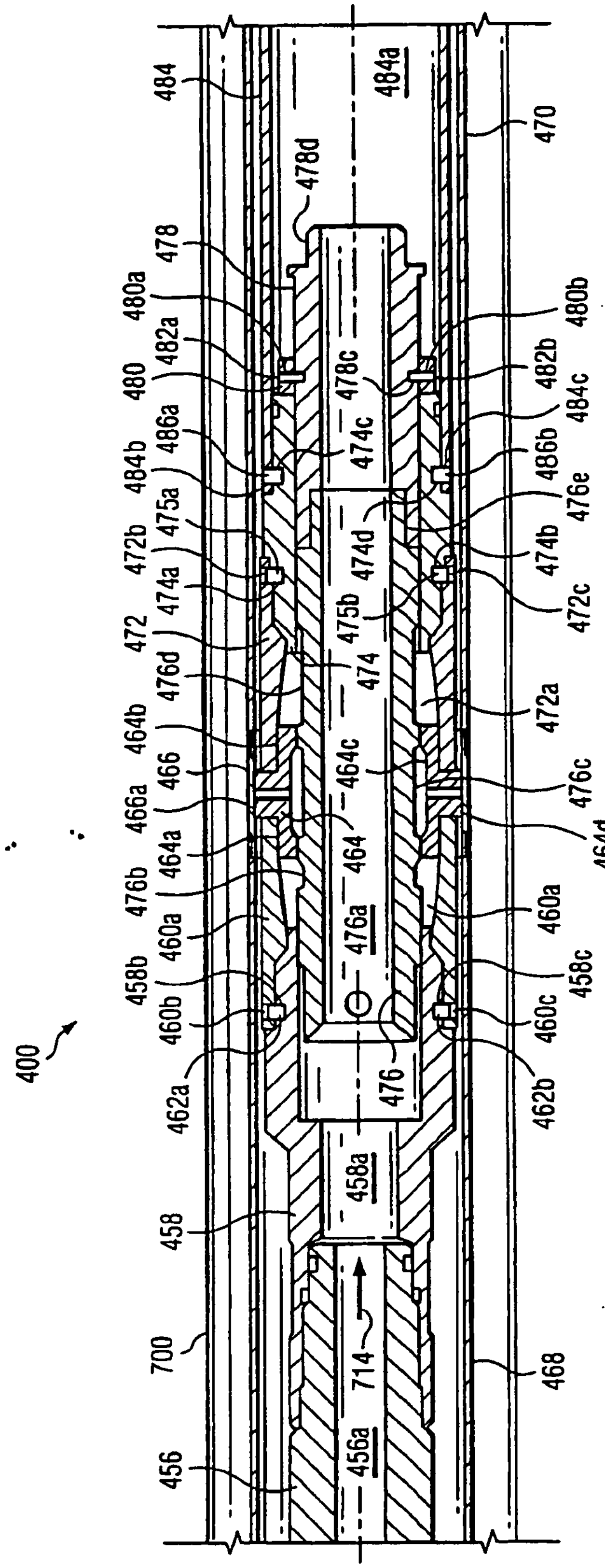
Fig. 35c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472c
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476d
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476c
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462b
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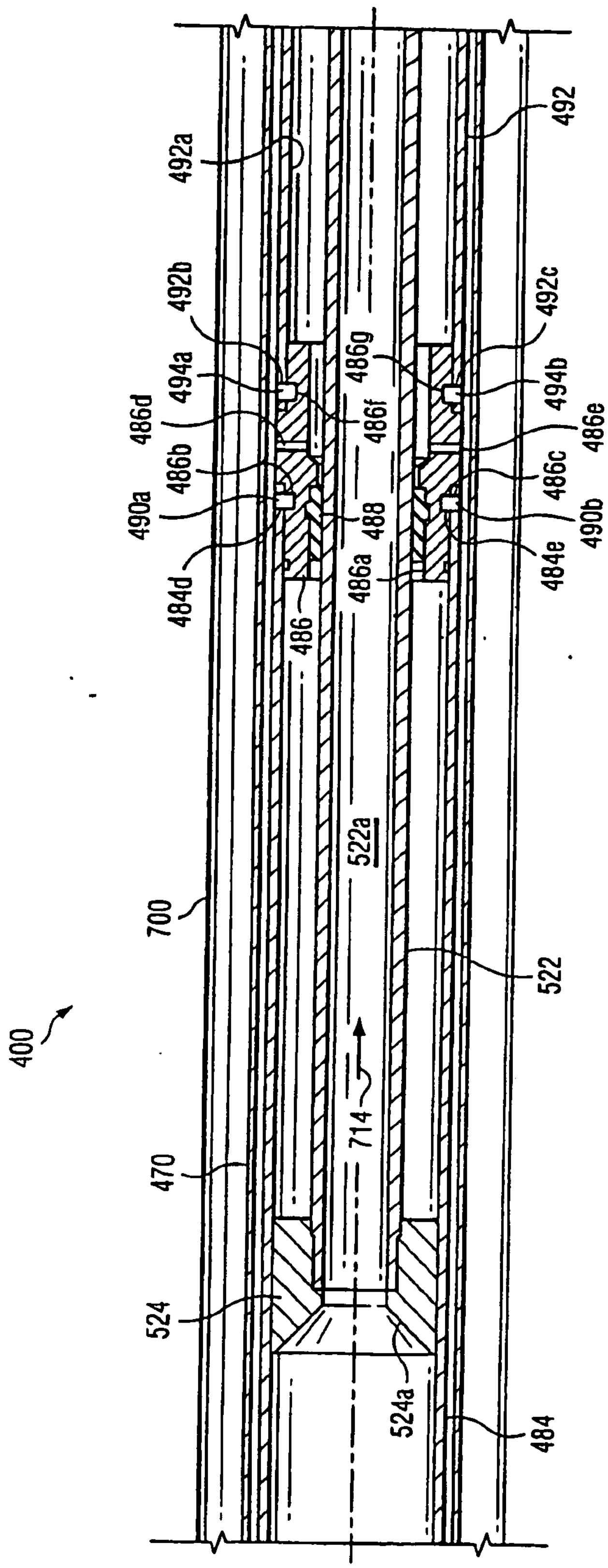
458a
700
714
468
456
456a

Fig. 35d



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486c
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490b
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714
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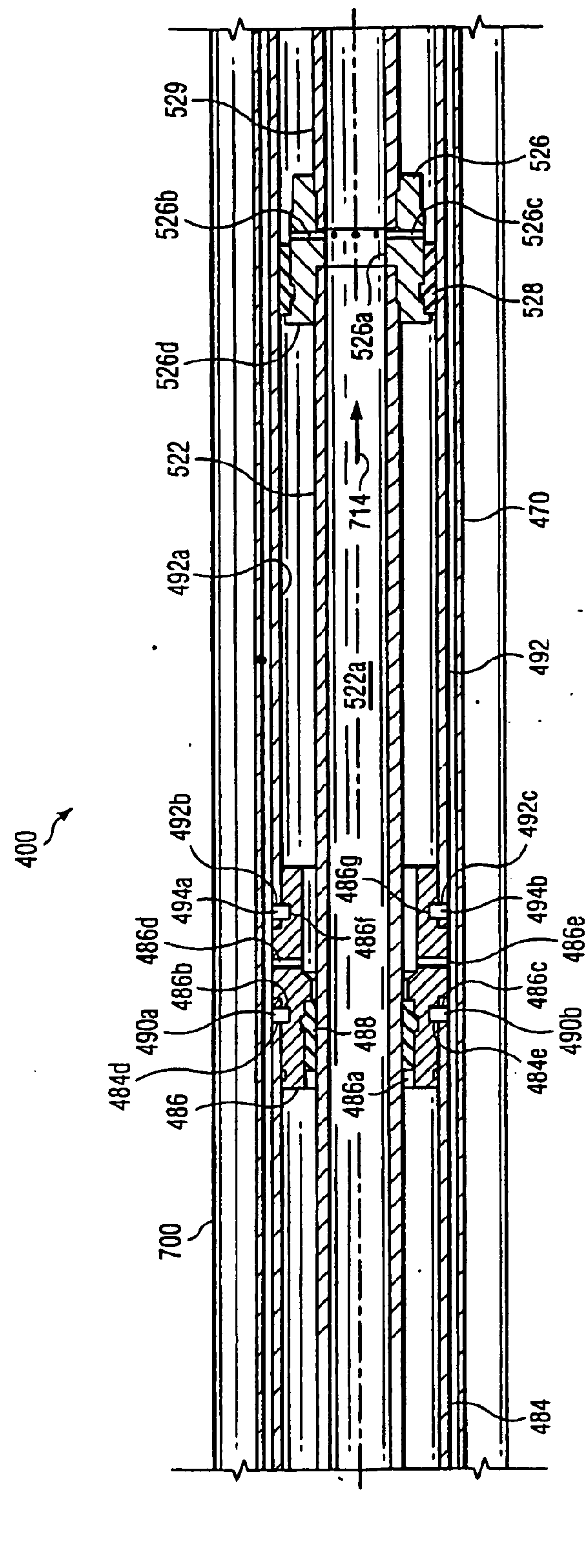
524a
484

Fig. 35e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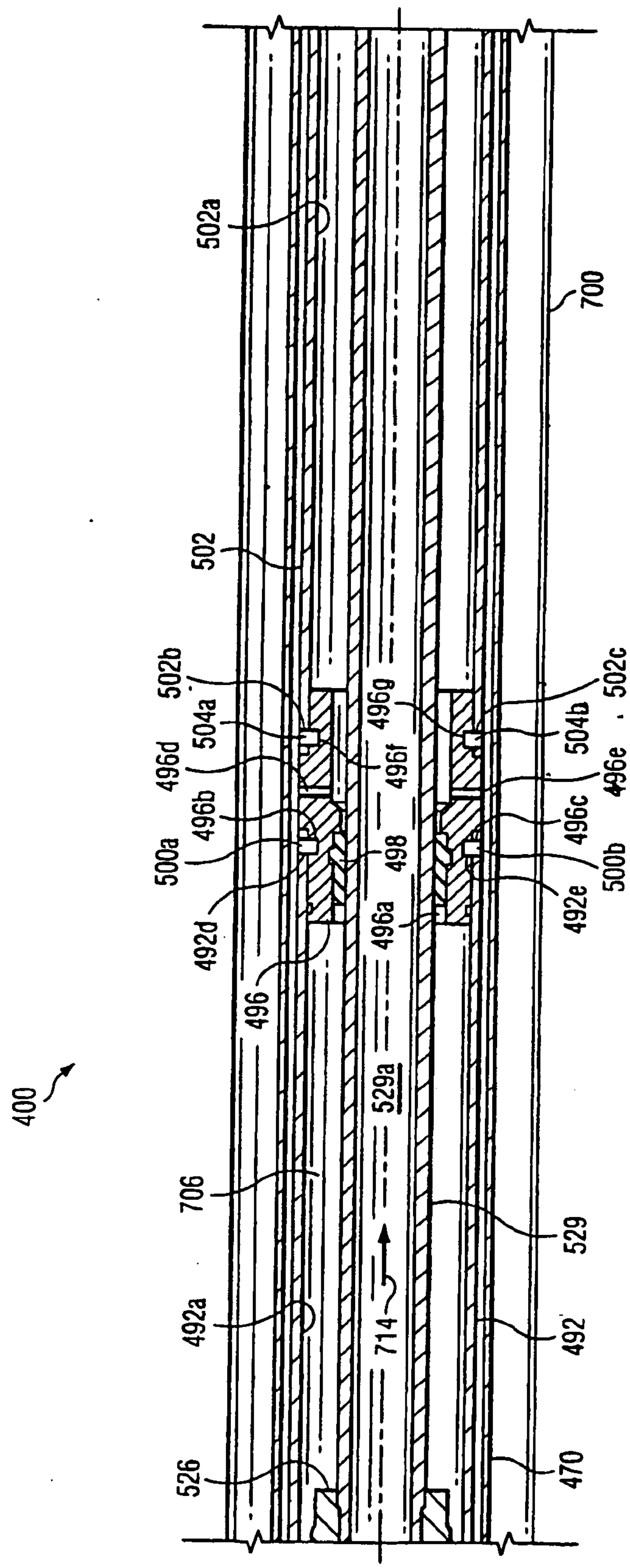
486a
484e
486
700
484

Fig. 35f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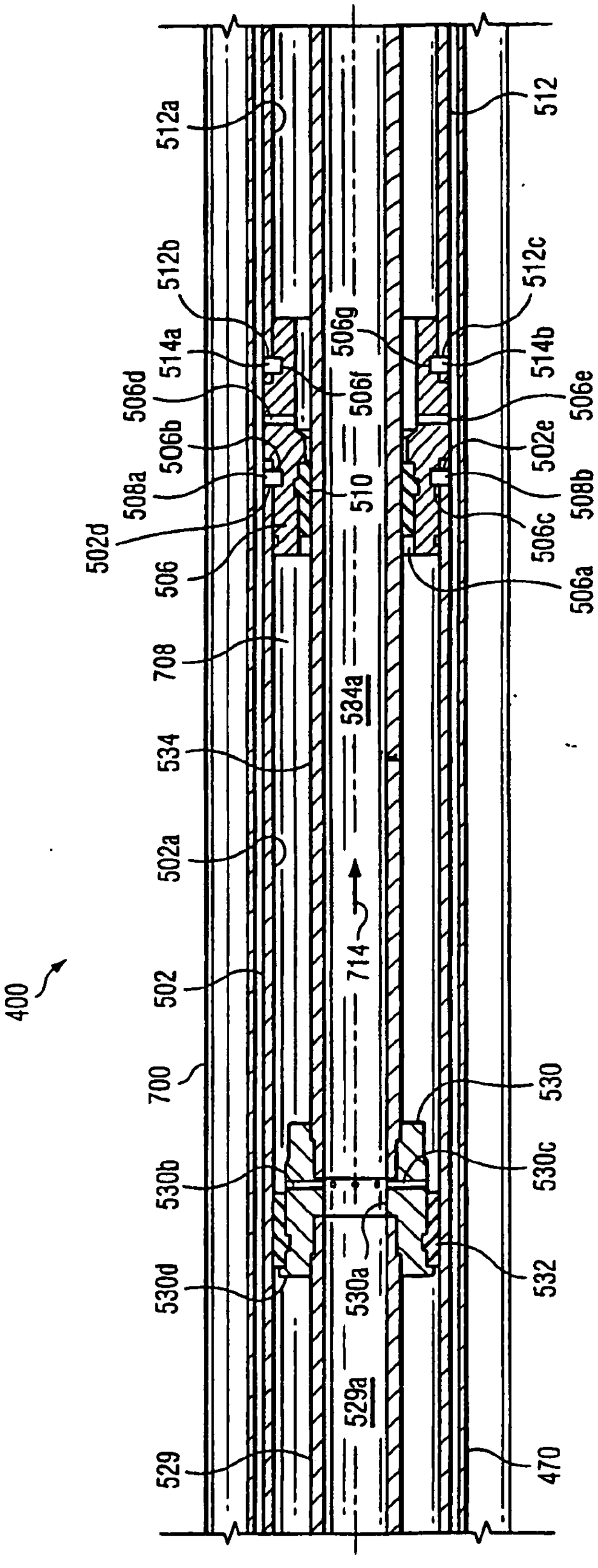
496a
529a
714
700
502c
504b
496e
496c
500b
492e
529
492
470

Fig. 35g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506c
506
506a
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534
502a
714
502
700
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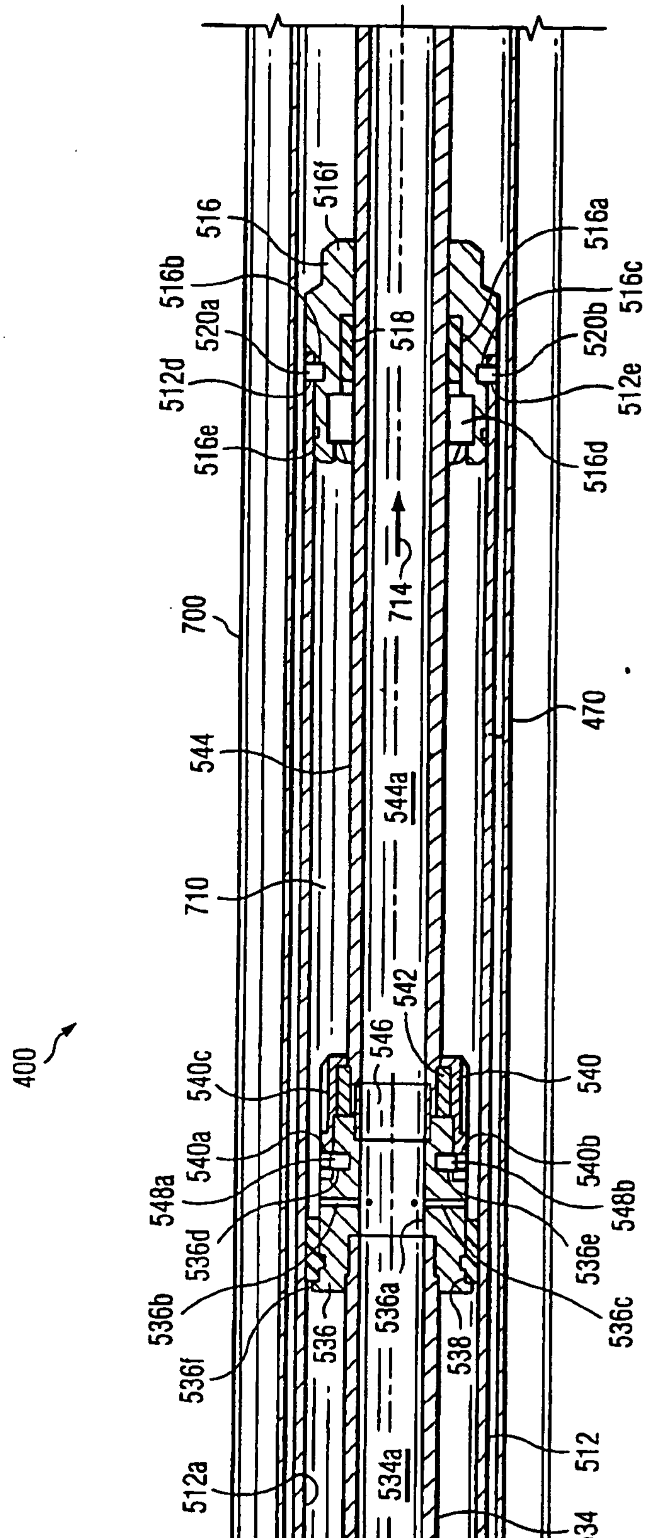
530c
530d
530a
532
529a
529
470

Fig. 35h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516d
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540c
540a
548a
536d
536b
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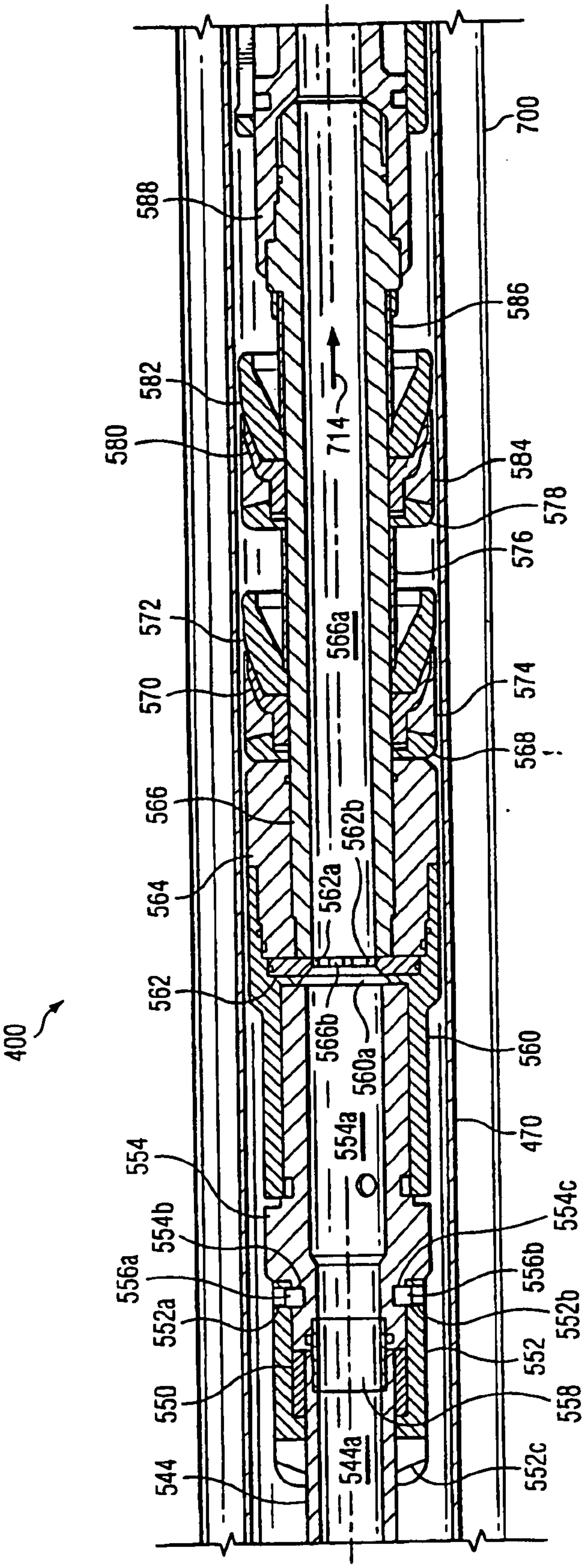
546
542
540
540b
548b
536e
536c
536
536a
538
512a
534a
512
534

Fig. 35i



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588
586
582
714
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584
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570
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568
566
562b
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562
566b
560a
560
400
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554c
554b
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556b
552a
552b
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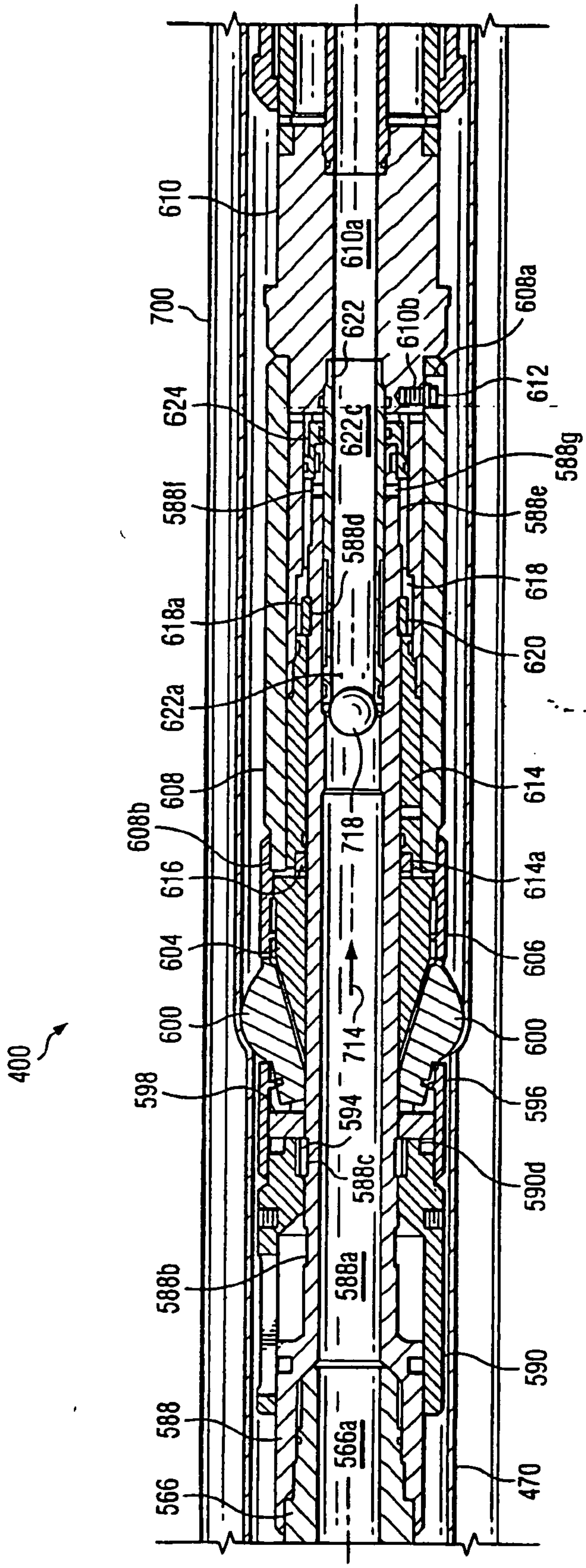
550
558
544a
544
552c

Fig. 35j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622c
588d
718
714
594
588c
588a
566a
608a
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588g
588e
618
620
614
614a
606
600
596
590d
590
470

Fig. 35k

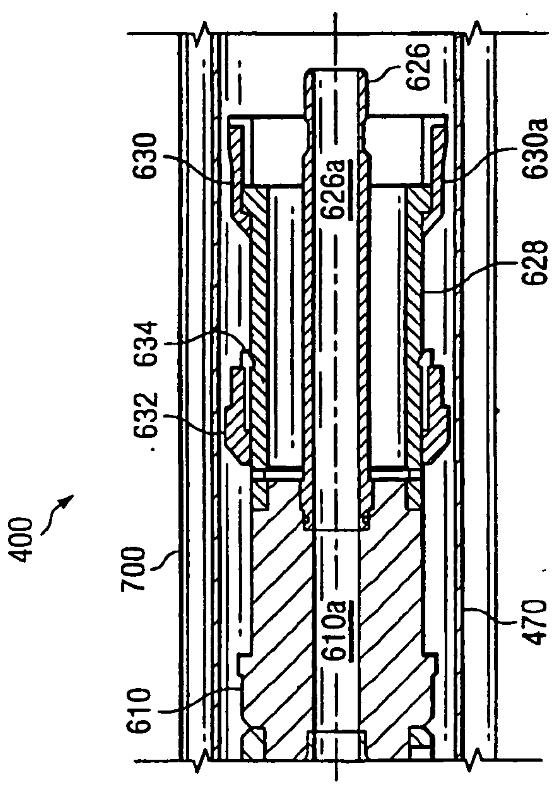
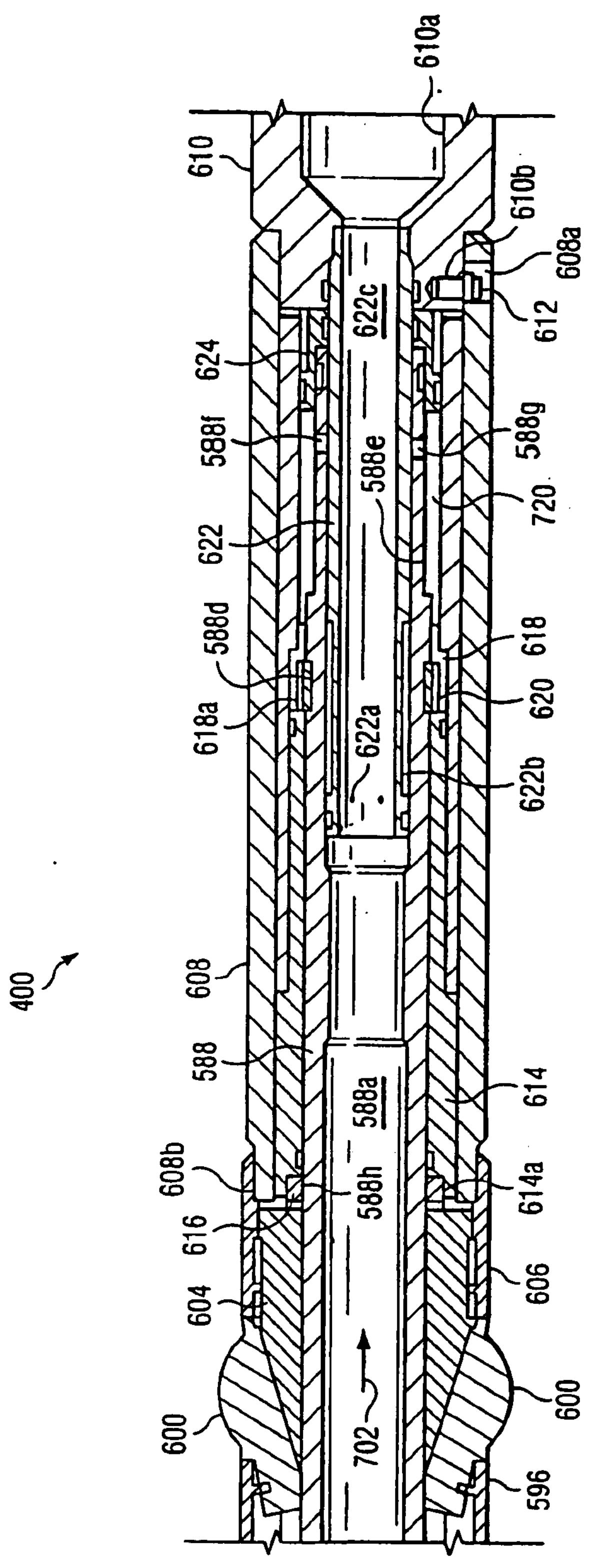


Fig. 35I



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610
610b
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622c
588f
588g
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720
622
588d
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618a
620
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614a
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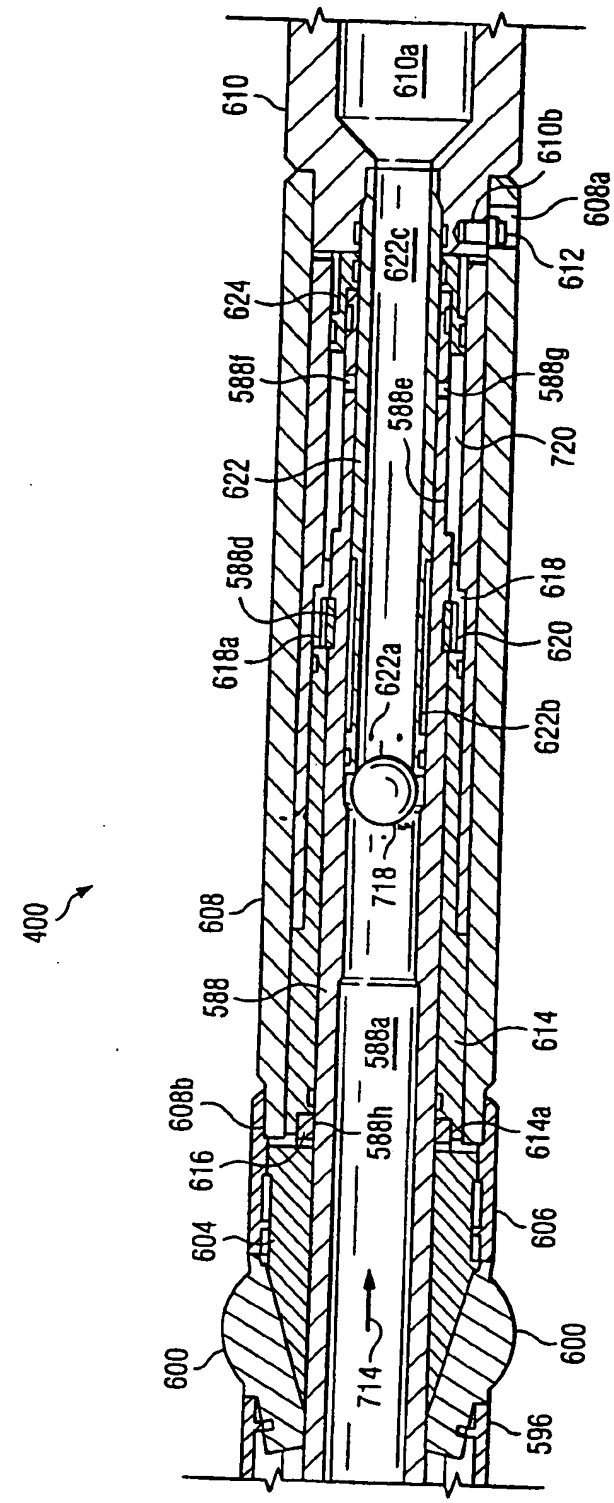
600
702
596

Fig. 36a



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610a
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588g
720
622
588d
618
618a
622a
620
622b
718
400
608
588
588a
614
608b
588h
614a
616
604
606
714
600
600
596

Fig. 36b

2414749

MONO DIAMETER WELLBORE CASING

Cross Reference To Related Applications

The present application claims the benefit of the filing dates of (1) U.S. provisional patent application serial no. 60/338,996, attorney docket no. 25791.87, filed on 11/12/2001, (2) U.S. provisional patent application serial no. 60/339,013, attorney docket no. 88, filed on 11/12/01 (3) U.S. provisional patent application serial no. 60/363,829, attorney docket no. 25791.95, filed on 3/13/2002, (4) U.S. provisional patent application serial no. 60/387,961, attorney docket no. 25791.108, filed on 6/12/2002 the disclosures of which are incorporated herein by reference.

The present application is related to the following: (1) U.S. patent application serial no. 09/454,139, attorney docket no 25791.03.02, filed on 12/3/1999, (2) U.S. patent application serial no. 09/510,913, attorney docket no. 25791.7.02, filed on 2/23/2000, (3) U.S. patent application serial no. 09/502,350, attorney docket no. 25791.8.02, filed on 2/10/2000, (4) U.S. patent no. 6,328,113, (5) U.S. patent application serial no. ·9/523,460, attorney docket no. 25791.11.02, filed on 3/10/2000, (6) U.S. patent application serial no. 09/512,895, attorney docket no. 25791.12.02, filed on 2/24/2000, (7) U.S. patent application serial no. 09/511,941, attorney docket no. 25791.16.02, filed on 2/24/2000, (8) U.S. patent application serial no. 09/588,946, attorney docket no. 25791.17.02, filed on 6/7/2000, (9) U.S. patent application serial no. 09/559,122, attorney docket no. 25791.23.02, filed on 4/26/2000, (10) PCT patent application serial no. PCT/US00/18635, attorney docket no 25791.25.02, filed on 7/9/2000, (11) U.S. provisional patent application serial no. 60/162,671, attorney docket no. 25791.27, filed on 11/1/1999, (12) U.S. provisional patent application serial no. 60/154,047, attorney docket no. 25791.29, filed on 9/16/1999, (13) U.S. provisional patent application serial no. 60/159,082, attorney docket no. 25791.34, filed on 10/12/1999, (14) U.S. provisional patent application serial no. 60/159,039, attorney docket no. 25791.36, filed on 10/12/1999, (15) U.S. provisional patent application serial no. 60/159,033, attorney docket no. 25791.37, filed on 10/12/1999, (16) U.S. provisional patent application serial no. 60/212,359, attorney docket no. 25791.38, filed on 6/19/2000, (17) U.S provisional patent application serial no. 60/165,228, attorney docket no. 25791.39, filed on 11/12/1999, (18) U.S. provisional patent application serial no. 60/221,443, attorney

docket no. 25791.45, filed on 7/28/2000, (19) U.S. provisional patent application serial no. 60/221,645, attorney docket no. 25791.46, filed on 7/28/2000, (20) U.S. provisional patent application serial no. 60/233,638, attorney docket no. 25791.47, filed on 9/18/2000, (21) U.S. provisional patent application serial no. 60/237,334, attorney docket no. 25791.48, filed on 10/2/2000, (22) U.S. provisional patent application serial no. 60/270,007, attorney docket no 25791 50, filed on 2/20/2001, (23) U.S. provisional patent application serial no. 60/262,434, attorney docket no. 25791.51, filed on 1/17/2001, (24) U.S, provisional patent application serial no. 60/259,486, attorney docket no. 25791.52, filed on 1/3/2001, (25) U.S. provisional patent application serial no. 60/303,740, attorney docket no. 25791.61, filed on 7/6/2001, (26) U.S. provisional patent application serial no 60/313,453, attorney docket no. 25791.59, filed on 8/20/2001, (27) U.S. provisional patent application serial no. 60/317,985, attorney docket no. 25791.67, filed on 9/6/2001, (28) U.S. provisional patent application serial no. 60/318,021, attorney docket no. 25791.58, filed on 9/7/2001, (29) U.S. provisional patent application serial no. 60/3318,386, attorney docket no 25791.67.02, filed on 9/10/2001, (30) U.S. provisional patent application serial no. 60/326,886, attorney docket no. 25791.60, filed on 10/3/2001, (31) U.S. utility patent application serial no. 09/96·,922, attorney docket no. 25791.69, filed on 10/3/2·01, (32) U.S. provisional patent application serial no. 60/338,996, attorney docket no. 25791.87, filed on 11/12/2001, (33) U.S. provisional patent application serial no. 60/339,013, attorney docket no. 25791.88, filed on 11/12/2001, (34) U.S. utility patent application serial no. 10/016,467, attorney docket no. 25791.70, filed on 12/10/2001, (35) U.S. provisional patent application serial no. 60/343,674, attorney docket no. 25791.68, filed on 12/27/2001, (36) U.S. provisional patent application serial no. 60/346,309, attorney docket no 25791.92, filed on 1/7/2002, (37) U.S. provisional patent application serial no. 60/357,372, attorney docket no. 25791.71, filed on 2/15/2002, (38) U.S. provisional patent application serial no. 60/363,829, attorney docket no. 25791.95, filed on 3/13/2002, (39) U.S. provisional patent application serial no. 60/372,048, attorney docket no 25791.93, filed on 4/12/2002, (40) U.S. provisional patent application serial no. 60/372,632, attorney docket no. 25791 101, filed on 4/15/2002, (41) U.S. provisional patent application serial no. 60/380,147, attorney docket no. 25791.104, filed on 5/6/2002, (42) U.S. provisional patent application serial no. 60/383,917, attorney docket no. 25791.89, filed on 5/29/2002, (43) U.S. provisional patent application serial no. 60/387,486, attorney docket no. 25791.107, filed on 6/10/2002,

(44) U.S. provisional patent application serial no. 60/387,961, attorney docket no. 25791.108, filed on 6/12/2002, (45) U.S. provisional patent application serial no. 60/391,703, attorney docket no. 25791.90, filed on 6/26/2002, (46) U.S. provisional patent application serial no. 60/397,284, attorney docket no. 25791 106, filed on 7/19/2002, (47) U S. provisional patent application serial no. 60/398,061, attorney docket no. 25791.110, filed on 7/24/2002, (48) U.S. provisional patent application serial no. 60/399,240, attorney docket no 25791.111, filed on 7/29/2002, (49) U.S. provisional patent application serial no, 60/405,610, attorney docket no. 25791.119, filed on 8/23/2002, (50) U.S. provisional patent application serial no. 60/405,394, attorney docket no 25791.120, filed on 8/23/2002, (51) U.S. provisional patent application serial no. 60/407,442, attorney docket no. 25791.125, filed on 8/30/2002, (52) U.S. provisional patent application serial no. 60/412,542, attorney docket no. 25791.102, filed on 9/20/2002, (53) U S. provisional patent application serial no. 60/412,177, attorney docket no. 25791.117, filed on 9/20/2002, (54) U.S. provisional patent application serial no. 60/412,653, attorney docket no. 25791.118, filed on 9/20/2002, (55) U.S provisional patent application serial no 60/412,544, attorney docket no. 25791.121, filed on 9/20/2002, (56) U.S. provisional patent application serial no. 60/412,187, attorney docket no. 25791.128, filed on 9/20/2002, (57) U.S. provisional patent application serial no 60/412,187, attorney docket no. 25791.127, filed on 9/20/2002, (58) U.S. provisional patent application serial no. 60/412,487, attorney docket no. 25791.127, filed on 9/20/2002, (58) U.S. provisional patent application serial no. 60/412,487, attorney docket no. 25791.112, filed on 9/20/2002, (59) U.S. provisional patent application serial no. 60/412,488, attorney docket no. 25791.114, filed on 9/20/2002, and (60) U.S. provisional patent application serial no. 60/412,371, attorney docket no. 25791.129, filed on 9/20/2002, (61) PCT Patent Application No. PCT/US02_______, attorney docket no. 25791.87.02, filed on 11/11/02 and (62) PCT Patent Application No. PCT/US02_______, attorney docket no. 25791.88 02, filed on 11/11/02 the disclosures of which are incorporated herein by reference.

Background Of The Invention

This invention relates generally to oil and gas exploration, and in particular to forming and repairing wellbore casings to facilitate oil and gas exploration.

Conventionally, when a wellbore is created, a number of casings are installed in the borehole to prevent collapse of the borehole wall and to prevent undesired outflow of drilling fluid into the formation or inflow of fluid from the formation into the borehole. The borehole is drilled in intervals whereby a casing which is to be installed in a lower borehole interval is lowered through a previously installed casing of an upper borehole interval. As a consequence of this procedure the casing of the lower interval is of smaller diameter than the casing of the upper interval. Thus, the casings are in a nested arrangement with casing diameters decreasing in downward direction Cement annuli are provided between the outer surfaces of the casings and the borehole wall to seal the casings from the borehole wall. As a consequence of this nested arrangement a relatively large borehole diameter is required at the upper part of the wellbore. Such a large borehole diameter involves increased costs due to heavy casing handling equipment, large drill bits and increased volumes of drilling fluid and drill cuttings. Moreover, increased drilling rig time is involved due to required cement pumping, cement hardening, required equipment changes due to large variations in hole diameters drilled in the course of the well, and the large volume of cuttings drilled and removed.

The present invention is directed to overcoming one or more of the limitations of the existing procedures for forming and/or repairing wellbore casings.

Summary of the Invention

According to one aspect of the present invention, an apparatus for radially expanding and plastically deforming an expandable tubular member is provided that includes a float shoe adapted to mate with an end of the expandable tubular member, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, and a support member coupled to the locking device.

According to another aspect of the present invention, a method for radially expanding and plastically deforming an expandable tubular member within a borehole is provided that includes positioning an adjustable expansion mandrel within the expandable tubular member, supporting the expandable tubular member and the adjustable expansion mandrel within the borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member.

According to another aspect of the present invention, a method for forming a mono diameter wellbore casing is provided that includes positioning an adjustable expansion mandrel within a first expandable tubular member, supporting the first expandable tubular member and the adjustable expansion mandrel within a borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the borehole, positioning the adjustable expansion mandrel within a second expandable tubular member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the borehole.

According to another aspect of the present invention, an apparatus for radially expanding and plastically deforming an expandable tubular member is provided that includes a float shoe adapted to mate with an end of the expandable tubular member, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular

member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, a support member coupled to the locking device, and a sealing member for sealingly engaging the expandable tubular member adapted to define a pressure chamber above the adjustable expansion mandrel during radial expansion of the expandable tubular member.

According to another aspect of the present invention, a method for radially expanding and plastically deforming an expandable tubular member within a borehole is provided that includes positioning an adjustable expansion mandrel within the expandable tubular member, supporting the expandable tubular member and the adjustable expansion mandrel within the borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member within the borehole, and pressurizing an interior region of the expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the expandable tubular member within the borehole.

According to another aspect of the present invention, a method for forming a mono diameter wellbore casing is provided that includes positioning an adjustable expansion mandrel within a first expandable tubular member, supporting the first expandable tubular member and the adjustable expansion mandrel within a borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the borehole, pressurizing an interior region of the first expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the first expandable tubular member within the borehole, positioning the adjustable expansion mandrel within a second expandable tubular

member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the borehole, and pressurizing an interior region of the second expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the second expandable tubular member within the borehole.

According to another aspect of the present invention, an apparatus for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole is provided that includes a float shoe adapted to mate with an end of the expandable tubular member, a drilling member coupled to the float shoe adapted to drill the borehole, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, and a support member coupled to the locking device.

According to another aspect of the present invention, a method for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole is provided that include positioning an adjustable expansion mandrel within the expandable tubular member, coupling a drilling member to an end of the expandable tubular member, drilling the borehole using the drilling member, positioning the adjustable expansion mandrel and the expandable tubular member within the drilled borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to

radially expand and plastically deform n portions of the expandable tubular member within the drilled borehole.

According to another aspect of the present invention, a method for forming a mono diameter wellbore casing within a borehole is provided that includes positioning an adjustable expansion mandrel within a first expandable tubular member, coupling a drilling member to an end of the first expandable tubular member, drilling a first section of the borehole using the drilling member, supporting the first expandable tubular member and the adjustable expansion mandrel within the drilled first section of the borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the drilled first section of the borehole, positioning the adjustable expansion mandrel within a second expandable tubular member, coupling the drilling member to an end of the second expandable tubular member, drilling a second section of the borehole using the drilling member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member within the second drilled section of the borehole, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the drilled second section of the borehole.

According to another aspect of the present invention, an apparatus for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole is provided that includes a float shoe adapted to mate with an end of the expandable tubular member, a drilling member coupled to the float shoe adapted to drill the borehole, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable

expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, a support member coupled to the locking device, and a sealing member for sealing engaging the expandable tubular member adapted to define a pressure chamber above the adjustable expansion mandrel during the radial expansion of the expandable tubular member.

According to another aspect of the present invention, a method for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole is provided that includes positioning an adjustable expansion mandrel within the expandable tubular member, coupling a drilling member to an end of the expandable tubular member, drilling the borehole using the drilling member, positioning the adjustable expansion mandrel and the expandable tubular member within the drilled borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member within the drilled borehole, and pressuring an interior portion of the expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the expandable tubular member within the drilled borehole.

According to another aspect of the present invention, a method for forming a mono diameter wellbore casing within a borehole is provided that includes positioning an adjustable expansion mandrel within a first expandable tubular member, coupling a drilling member to an end of the first expandable tubular member, drilling a first section of the borehole using the drilling member, supporting the first expandable tubular member and the adjustable expansion mandrel within the drilled first section of the borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the drilled first section of the borehole, pressuring

an interior portion of the first expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the first expandable tubular member within the first drilled section of the borehole, positioning the adjustable expansion mandrel within a second expandable tubular member, coupling the drilling member to an end of the second expandable tubular member, drilling a second section of the borehole using the drilling member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member within the second drilled section of the borehole, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the drilled second section of the borehole, and pressuring an interior portion of the second expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the second expandable tubular member within the drilled second section of the borehole.

According to another aspect of the present invention, an apparatus for radially expanding and plastically deforming an expandable tubular member is provided that includes a float shoe adapted to mate with an end of the expandable tubular member, a first adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a first larger outside dimension for radial expansion of the expandable tubular member or collapsed to a first smaller outside dimension, a second adjustable expansion mandrel coupled to the first adjustable expansion mandrel adapted to be controllably expanded to a second larger outside dimension for radial expansion of the expandable tubular member or collapsed to a second smaller outside dimension, an actuator coupled to the first and second adjustable expansion mandrels adapted to controllably displace the first and second adjustable expansion mandrels relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, and a support member coupled to the locking device. The first larger outside dimension of the first adjustable expansion mandrel is larger than the second larger outside dimension of the second adjustable expansion mandrel.

According to another aspect of the present invention, a method for radially expanding and plastically deforming an expandable tubular member within a borehole is provided that includes positioning first and second adjustable expansion mandrels within the expandable tubular member, supporting the expandable tubular member and the first and second adjustable expansion mandrels within the borehole, lowering the first adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform a lower portion of the expandable tubular member, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, and displacing the second adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform portions of the expandable tubular member above the lower portion of the expandable tubular member. The outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

According to another aspect of the present invention, a method for forming a mono diameter wellbore casing is provided that includes positioning first and second adjustable expansion mandrels within a first expandable tubular member, supporting the first expandable tubular member and the first and second adjustable expansion mandrels within a borehole, lowering the first adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform a lower portion of the first expandable tubular member, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the first expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly relative to the first expandable tubular member

to radially expand and plastically deform portions of the first expandable tubular member above the lower portion of the expandable tubular member, positioning first and second adjustable expansion mandrels within a second expandable tubular member, supporting the first expandable tubular member and the first and second adjustable expansion mandrels within the borehole in overlapping relation to the first expandable tubular member, lowering the first adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform a lower portion of the second expandable tubular member, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the second expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, and displacing the second adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform portions of the second expandable tubular member above the lower portion of the second expandable tubular member. The outside dimension of the firs· adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

According to another aspect of the present invention, an apparatus for radially expanding and plastically deforming an expandable tubular member is provided that includes a float shoe adapted to mate with an end of the expandable tubular member, a first adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a first larger outside dimension for radial expansion of the expandable tubular member or collapsed to a first smaller outside dimension, a second adjustable expansion mandrel coupled to the first adjustable expansion mandrel adapted to be controllably expanded to a second larger outside dimension for radial expansion of the expandable tubular member or collapsed to a second smaller outside dimension, an actuator coupled to the first and second adjustable expansion mandrels adapted to controllably displace the first and second adjustable expansion mandrels relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, a support member coupled to the locking device, and a sealing member for sealingly engaging the expandable tubular

adapted to define a pressure chamber above the first and second adjustable expansion mandrels during the radial expansion of the expandable tubular member. The first larger outside dimension of the first adjustable expansion mandrel is larger than the second larger outside dimension of the second adjustable expansion mandrel.

According to another aspect of the present invention, a method for radially expanding and plastically deforming an expandable tubular member within a borehole is provided that includes positioning first and second adjustable expansion mandrels within the expandable tubular member, supporting the expandable tubular member and the first and second adjustable expansion mandrels within the borehole, lowering the first adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform a lower portion of the expandable tubular member, pressurizing an interior region of the expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the expandable tubular member by the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform portions of the expandable tubular member above the lower portion of the expandable tubular member, and pressurizing an interior region of the expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the expandable tubular member above the lower portion of the expandable tubular member by the second adjustable expansion mandrel. The outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

According to another aspect of the present invention, a method for forming a mono diameter wellbore casing is provided that includes positioning first and second adjustable expansion mandrels within a first expandable tubular member, supporting the first expandable tubular member and the first and second adjustable expansion

mandrels within a borehole, lowering the first adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform a lower portion of the first expandable tubular member, pressurizing an interior region of the first expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the first expandable tubular member by the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the first expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform portions of the first expandable tubular member above the lower portion of the expandable tubular member, pressurizing an interior region of the first expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the first expandable tubular member above the lower portion of the first expandable tubular member by the second adjustable expansion mandrel, positioning first and second adjustable expansion mandrels within a second expandable tubular member, supporting the first expandable tubular member and the first and second adjustable expansion mandrels within the borehole in overlapping relation to the first expandable tubular member, lowering the first adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform a lower portion of the second expandable tubular member, pressurizing an interior region of the second expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the second expandable tubular member by the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the second expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly

relative to the second expandable tubular member to radially expand and plastically deform portions of the second expandable tubular member above the lower portion of the second expandable tubular member, and pressurizing an interior region of the second expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the second expandable tubular member above the lower portion of the second expandable tubular member by the second adjustable expansion mandrel. The outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

According to another aspect of the present invention, an apparatus for radially expanding and plastically deforming an expandable tubular member is provided that includes a support member, a locking device coupled to the support member and releasably coupled to the expandable tubular member, an adjustable expansion mandrel adapted to be controllably expanded to a larger outside dimension for radial expansion and plastic deformation of the expandable tubular member or collapsed to a smaller outside dimension; and an actuator coupled to the locking member and the adjustable expansion mandrel adapted to displace the adjustable expansion mandrel upwardly through the expandable tubular member to radially expand and plastically deform the expandable tubular member.

According to another aspect of the present invention, a method for radially expanding and plastically deforming an expandable tubular member within a borehole is provided that includes supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion mandrel within the borehole, increasing the size of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member.

According to another aspect of the present invention, a method for forming a mono diameter wellbore casing within a borehole that includes a preexisting wellbore casing is provided that includes supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion mandrel within the borehole, increasing the size of the adjustable expansion mandrel, displacing the adjustable expansion mandrel

upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member, and displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member and a portion of the preexisting wellbore casing that overlaps with an end of the remaining portion of the expandable tubular member.

Brief Description of the Drawings

Fig. 1 is a fragmentary cross-sectional illustration of the placement of an embodiment of an apparatus for radially expanding and plastically deforming a tubular member within a preexisting structure.

Fig. 2 is a fragmentary cross-sectional illustration of apparatus of Fig. 1 after displacing the adjustable expansion mandrel and the float shoe downwardly out of the end of the expandable tubular member.

Fig. 3 is a fragmentary cross-sectional illustration of the apparatus of Fig. 2 after expanding the adjustable expansion mandrel.

Fig. 4 is a fragmentary cross-sectional illustration of the apparatus of Fig. 3 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 5 is a fragmentary cross-sectional illustration of the apparatus of Fig. 4 after displacing the actuator, locking device, and tubular support member upwardly relative to the adjustable expansion mandrel and the expandable tubular member.

Fig 6 is a fragmentary cross-sectional illustration of the apparatus of Fig. 5 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig 6a is a fragmentary cross-sectional illustration of the apparatus of Fig. 6 that include one or more cup seals positioned above the adjustable expansion mandrel for defining an annular pressure chamber above the adjustable expansion mandrel.

Fig. 7 is a fragmentary cross-sectional illustration of the placement of an embodiment of an apparatus for drilling a borehole and radially expanding and plastically deforming a tubular member within the drilled borehole.

Fig. 8 is a fragmentary cross-sectional illustration of the apparatus of Fig. 7 after pivoting the drilling elements of the drilling member radially inwardly

Fig. 9 is a fragmentary cross-sectional illustration of apparatus of Fig. 8 after displacing the adjustable expansion mandrel and drilling member downwardly out of the end of the expandable tubular member.

Fig. 10 is a fragmentary cross-sectional illustration of the apparatus of Fig. 9 after expanding the adjustable expansion mandrel.

Fig. 11 is a fragmentary cross-sectional illustration of the apparatus of Fig. 10 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 12 is a fragmentary cross-sectional illustration of the apparatus of Fig. 11 after displacing the actuator, locking device, and tubular support member upwardly relative to the adjustable expansion mandrel and the expandable tubular member.

Fig. 13 is a fragmentary cross-sectional illustration of the apparatus of Fig. 12 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member

Fig. 14 is a fragmentary cross-sectional illustration of the placement of an embodiment of an apparatus for radially expanding and plastically deforming a tubular member within a preexisting structure.

Fig. 15 is a fragmentary cross-sectional illustration of the apparatus of Fig. 14 after displacing the lower adjustable expansion mandrel and float shoe downwardly out of the end of the expandable tubular member.

Fig. 16 is a fragmentary cross-sectional illustration of the apparatus of Fig. 15 after expanding the lower adjustable expansion mandrel.

Fig. 17 is a fragmentary cross-sectional illustration of the apparatus of Fig. 16 after displacing the lower adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 18 is a fragmentary cross-sectional illustration of the apparatus of Fig. 17 after displacing the upper and lower adjustable expansion mandrels downwardly relative to the expandable tubular member.

Fig. 19 is a fragmentary cross-sectional illustration of the apparatus of Fig. 18 after collapsing the lower adjustable expansion mandrel and expanding the upper adjustable expansion mandrel

Fig. 20 is a fragmentary cross-sectional illustration of the apparatus of Fig. 19 after displacing the upper adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 21 is a fragmentary cross-sectional illustration of the apparatus of Fig. 20 after displacing the tubular support member, the locking device, and the actuator upwardly relative to the upper adjustable expansion mandrel and the expandable tubular member.

Fig. 22 is a fragmentary cross-sectional illustration of the apparatus of Fig. 21 after displacing the upper adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 23 is a fragmentary cross-sectional illustration of a mono diameter wellbore casing formed using one or more of the apparatus of Figs. 1-22.

Figs 24a-24k are fragmentary cross sectional illustrations of the placement of an exemplary embodiment of an apparatus for radially expanding and plastically deforming a tubular member within a wellbore that traverses a subterranean formation.

Fig. 25a-25f are fragmentary cross sectional and perspective illustrations of the expansion cone assembly of the apparatus of Figs. 24a-24k.

Fig. 25g is a perspective illustration of a float shoe locking dog.

Fig. 25h is a fragmentary cross sectional illustration of the design and operation of the casing gripper locking dogs.

Figs. 26a-26k are fragmentary cross sectional illustrations of the apparatus of Figs. 24a-24k after expanding the expansion cone assembly.

Figs. 27a-27b are a fragmentary cross sectional and perspective illustrations of the expansion cone assembly of the apparatus of Figs. 26a-26k.

Figs. 28a-28j are fragmentary cross sectional illustrations of the apparatus of Figs. 26a-26k during the upward displacement of the expansion cone assembly by the actuators to radially expand and plastically deform a portion of the casing.

Figs. 29a-29m are fragmentary cross sectional illustrations of the apparatus of Figs. 28a-28j after the collapse of the expansion cone assembly.

Fig. 30a-30c are fragmentary cross sectional illustrations of the process for collapsing the expansion cone assembly of the apparatus of Figs. 29a-29m.

Figs. 31a-31n are fragmentary cross sectional illustrations of the apparatus of Figs. 29a-29m after the plastic deformation and radial expansion of the sealing sleeve and the disengagement of the casing from the locking dogs of the casing lock assembly.

Figs. 32a-32k are fragmentary cross sectional illustrations of the apparatus of Figs. 31a-31n after setting down the apparatus onto the bottom of the wellbore to open the bypass valve in the shoe and expand the expansion cone assembly.

Figs. 33a-33p are fragmentary cross sectional illustrations of the apparatus of Figs. 32a-32k dunng the radial expansion and plastic deformation of the casing.

Figs. 34a-34l are fragmentary cross sectional ıllustrations of the apparatus of Figs. 33a-33p during the radial expansion and plastic deformation of a portion of the casing that overlaps within a preexisting wellbore casıng within the wellbore.

Figs. 35a-35l are fragmentary cross sectional illustrations of the apparatus of Figs. 28a-28j during the emergency collapse of the expansion cone assembly.

Figs. 36a-36b are fragmentary cross sectional illustrations of several exemplary embodıments of the operation of the pressure balance piston.

Detailed Descriptıon of the ustrative Embodiments

Referring to Fig. 1, an exemplary embodiment of an apparatus 10 for radially expanding and plastically deforming a tubular member 12 includes a tubular support member 14 that extends into the tubular member that is coupled to an end of a locking device 16 for controllably engaging the tubular member. Another end of the locking device 16 is coupled to a tubular support member 18 that is coupled to an end of an actuator 20. Another end of the actuator 20 is coupled to a tubular support member 22 that is coupled to an end of an adjustable expansion mandrel 24 for radially expanding and plastıcally deforming the tubular member 12. Another end of the adjustable expansıon mandrel 24 is coupled to a tubular support member 26 that is coupled to an end of a float shoe 28 that mates with and is at least partially received within a lower end of the tubular member 12. In an exemplary embodiment, the locking device 16, the tubular support member 18, the actuator 20, the tubular support member 22, the adjustable expansion mandrel 24, and the tubular support member 26 are positioned within the tubular member 12.

In an exemplary embodiment, the tubular member 12 includes one or more solid and/or slotted tubular members, and one or more of the solid and/or slotted tubular members include resilient sealing members coupled to the exterior surfaces of the solid and/or slotted tubular members for engaging the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore. In an exemplary embodiment, the tubular support members, 14, 18, 22, and 26 define corresponding passages, that may or may not be valveable, for conveying fluidic materials into and/or through the apparatus 10.

In an exemplary embodiment, the locking device 16 includes one or more conventional controllable locking devices such as, for example, slips and/or dogs for controllably engaging the tubular member 12 In an exemplary embodiment, the locking device 16 is controlled by injecting fluidic materials into the locking device.

In an exemplary embodiment, the actuator 20 is a conventional actuator that is adapted to displaced the adjustable expansion mandrel 24 and float shoe 28 upwardly or downwardly relative to the actuator.

In an exemplary embodiment, the adjustable expansion mandrel 24 is a conventional adjustable expansion mandrel that may be expanded to a larger outside dimension or collapsed to a smaller outside dimension and includes external surfaces for engaging the tubular member 12 to thereby radially expand and plastically deform the tubular member when the adjustable expansion mandrel is expanded to the larger outside dimension. In an alternative embodiment, the adjustable expansion mandrel 24 may include a rotary adjustable expansion device such as, for example, the commercially available rotary expansion devices of Weatherford International, Inc. In several alternative embodiments, the cross sectional profile of the adjustable expansion mandrel 24 for radial expansion operations may, for example, be an n-sided shape, where n may vary from 2 to infinity, and the side shapes may include straight line segments, arcuate segments, parabolic segments, and/or hyperbolic segments. In several alternative embodiments, the cross sectional profile of the adjustable expansion mandrel 24 may, for example, be circular, oval, elliptical, and/or multifaceted.

In an exemplary embodiment, the float shoe 28 is a conventional float shoe.

In an exemplary embodiment, the apparatus 10 is positioned within a preexisting structure 30 such as, for example, a wellbore that traverses a subterranean formation 32. The wellbore 30 may have any orientation from vertical to horizontal In several exemplary embodiments, the wellbore 30 may include one or more preexisting solid and/or slotted and/or perforated wellbore casings that may or may not overlap with one another within the wellbore.

As illustrated in Fig 2, the adjustable expansion mandrel 24 and the float shoe 28 are then displaced downwardly out of the tubular member 12 by the actuator 20. During the downward displacement of the adjustable expansion mandrel 24 and the float shoe 28 out of the tubular member 12, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 3, the adjustable expansion mandrel 24 is then expanded to the larger dimension. In several alternative embodiments, the adjustable expansion mandrel 24 may be expanded to the larger dimension by, for example, injecting a fluidic material into the adjustable expansion mandrel and/or by impacting the float shoe 28 on the bottom of the wellbore 30. After expanding the adjustable expansion mandrel 24 to the larger dimension, expansion surfaces 24a are defined on the adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12. In an exemplary embodiment, the expansion surfaces 24a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 4, the adjustable expansion mandrel 24 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion of the tubular member 12. In an exemplary embodiment, during the upward displacement of the adjustable expansion mandrel 24, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more

preexisting wellbore casings coupled to the wellbore 30. In an exemplary embodiment, the interface between the expansion surfaces 24a of the adjustable expansion mandrel 24 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the adjustable expansion mandrel and the tubular member.

As illustrated in Fig. 5, the locking device 16 is then disengaged from the tubular member 12, and the tubular member 12 is supported by the adjustable expansion mandrel 24. The tubular support member 14, the locking device 16, the tubular support member 18, and the actuator 20 are then displaced upwardly relative to the adjustable expansion mandrel 24.

As illustrated in Fig. 6, the locking device 16 then engages the tubular member 12 to maintain the tubular member in a stationary position relative to the tubular support member 14, and the adjustable expansion mandrel 24 is displaced upwardly relative by the actuator 20 to radially expand and plastically deform another portion of the tubular member.

In an exemplary embodiment, the operations of Figs. 5 and 6 are then repeated until the entire length of the tubular member 12 is radially expanded and plastically deformed by the adjustable expansion mandrel 24. In several alternative embodiments, the adjustable expansion mandrel 24 may be collapsed to the smaller dimension prior to the further, or complete, radial expansion and plastic deformation of the tubular member 12.

In several alternative embodiments, as illustrated in Fig. 6a, the apparatus 10 further includes one or more cup seals 34 that are coupled to the tubular support member 22 and engage the tubular member 12 to define an annular chamber 36 above the adjustable expansion cone 24, and fluidic materials 38 are injected into the tubular member 12 through passages defined within the tubular support member 14, the locking device 16, the tubular support member 18, the actuator 20, the tubular support member 22, the adjustable expansion mandrel 24, the tubular support member 26, and the float shoe 28 to thereby pressurize the annular chamber 36. In this manner, the resulting pressure differential created across the cup seals 34 causes the cup seals to

pull the adjustable expansion mandrel 24 upwardly to radially expand and plastically deform the tubular member 12. In several alternative embodiments, the injection of the fluidic material 38 into the tubular member 12 is provided in combination with, or in the alternative to, the upward displacement of the expansion mandrel 24 by the actuator 20. In several alternative embodiments, during the injection of the fluidic material 38, the locking device 16 is disengaged from the tubular member 12.

Referring to Fig 7, an alternative embodiment of an apparatus 100 for radially expanding and plastically deforming the tubular member 12 is substantially identical in design and operation to the apparatus 10 with the addition of one or more conventional drilling members 40a-40b that are pivotally coupled to the float shoe 28. During operation of the apparatus 100, the drilling members 40a-40b may be operated to extend the length and/or diameter of the wellbore 30, for example, by rotating the apparatus and/or by injecting fluidic materials into the apparatus to operate the drilling members.

As illustrated in Fig. 7, in an exemplary embodiment, the apparatus 100 is initially positioned within the preexisting structure 30.

As illustrated in Fig. 8, in an exemplary embodiment, the drilling members 40a-40b may then be pivoted inwardly in a conventional manner

As illustrated in Fig. 9 the adjustable expansion mandrel 24, the float shoe 28, and the drilling members 40a-40b are then displaced downwardly out of the tubular member 12 by the actuator 20. During the downward displacement of the adjustable expansion mandrel 24, the float shoe 28, and the drilling members 40a-40b out of the tubular member 12, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 10, the adjustable expansion mandrel 24 is then expanded to the larger dimension. In several alternative embodiments, the adjustable expansion mandrel 24 may be expanded to the larger dimension by, for example, injecting a fluidic material into the adjustable expansion mandrel and/or by impacting the drilling members 40a-40b on the bottom of the wellbore 30. After expanding the adjustable

expansion mandrel 24 to the larger dimension, expansion surfaces 24a are defined on the adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12. In an exemplary embodiment, the expansion surfaces 24a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 11, the adjustable expansion mandrel 24 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion of the tubular member 12. In an exemplary embodiment, during the upward displacement of the adjustable expansion mandrel 24, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore 30. In an exemplary embodiment, the interface between the expansion surfaces 24a of the adjustable expansion mandrel 24 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the adjustable expansion mandrel and the tubular member.

As illustrated in Fig. 12, the locking device 16 is then disengaged from the tubular member 12, and the tubular member 12 is supported by the adjustable expansion mandrel 24. The tubular support member 14, the locking device 16, the tubular support member 18, and the actuator 20 are then displaced upwardly relative to the adjustable expansion mandrel 24.

As illustrated in Fig. 13, the locking device 16 then engages the tubular member 12 to maintain the tubular member in a stationary position relative to the tubular support member 14, and the adjustable expansion mandrel 24 is displaced upwardly relative by the actuator 20 to radially expand and plastically deform another portion of the tubular member.

In an exemplary embodiment, the operations of Figs. 12 and 13 are then repeated until the entire length of the tubular member 12 is radially expanded and plastically deformed by the adjustable expansion mandrel 24. In several alternative embodiments, the adjustable expansion mandrel 24 may be collapsed to the smaller dimension prior to the further, or complete, radial expansion and plastic deformation of the tubular member 12.

Referring to Fig. 14, an alternative embodiment of an apparatus 200 for radially expanding and plastically deforming the tubular member 12 is substantially identical in design and operation to the apparatus 10 except that the adjustable expansion mandrel 24 has been replaced by an upper adjustable expansion mandrel 202 that is coupled to the tubular support member 22, a tubular support member 204 that is coupled to the upper adjustable expansion mandrel, and a lower adjustable expansion mandrel 206 that is coupled to the tubular support member 204 and the tubular support member 26.

The upper and lower adjustable expansion mandrels, 202 and 206, may be conventional adjustable expansion mandrels that may be expanded to larger outside dimensions or collapsed to smaller outside dimensions and include external surfaces for engaging the tubular member 12 to thereby radially expand and plastically deform the tubular member when the adjustable expansion mandrels are expanded to the larger outside dimensions. In an alternative embodiment, the upper and/or lower adjustable expansion mandrels, 202 and 206, may include rotary adjustable expansion devices such as, for example, the commercially available rotary expansion devices of Weatherford International, Inc. In an exemplary embodiment, the tubular support member 204 defines a passage, that may, or may not, be valveable, for conveying fluidic materials into and/or through the apparatus 200. In several alternative embodiments, the cross sectional profiles of the adjustable expansion mandrels, 202 and 206, for radial expansion operations may, for example, be n-sided shapes, where n may vary from 2 to infinity, and the side shapes may include straight line segments, arcuate segments, parabolic segments, and/or hyperbolic segments. In several alternative embodiments, the cross sectional profiles of the adjustable expansion mandrels, 202 and 206, may, for example, be circular, oval, elliptical, and/or multifaceted.

As illustrated in Fig 14, in an exemplary embodiment, the apparatus 200 is initially positioned within the preexisting structure 30.

As illustrated in Fig. 15, the lower adjustable expansion mandrel 206 and the float shoe 28 are then displaced downwardly out of the tubular member 12 by the actuator 20. During the downward displacement of the lower adjustable expansion mandrel 206 and the float shoe 28 out of the tubular member 12, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 16, the lower adjustable expansion mandrel 206 is then expanded to the larger dimension. In several alternative embodiments, the lower adjustable expansion mandrel 206 may be expanded to the larger dimension by, for example, injecting a fluidic material into the lower adjustable expansion mandrel and/or by impacting the float shoe 28 on the bottom of the wellbore 30. After expanding the lower adjustable expansion mandrel 206 to the larger dimension, expansion surfaces 206a are defined on the lower adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12. In an exemplary embodiment, the expansion surfaces 206a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 17, the lower adjustable expansion mandrel 206 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion 12a of the tubular member 12 In an exemplary embodiment, during the upward displacement of the lower adjustable expansion mandrel 206, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore 30. In an exemplary embodiment, the interface between the expansion surfaces 206a of the lower adjustable expansion mandrel 206 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the lower adjustable expansion mandrel and the tubular member. In an exemplary embodiment,

the expansion surfaces 206a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member

As illustrated in Fig. 18, the upper and lower adjustable expansion mandrels, 202 and 206, and the float shoe 28 are then displaced downwardly by the actuator 20. During the downward displacement of the upper and lower adjustable expansion mandrels, 202 and 206, and the float shoe 28, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 19, the upper adjustable expansion mandrel 202 is then expanded to the larger dimension and the lower adjustable expansion mandrel 206 is collapsed to the smaller dimension. In an exemplary embodiment, the larger dimension of the upper adjustable expansion mandrel 202 is less than the larger dimension of the lower adjustable expansion mandrel 206 In several alternative embodiments, the upper adjustable expansion mandrel 202 may be expanded to the larger dimension and the lower adjustable expansion mandrel 206 may be collapsed to the smaller dimension by, for example, injecting fluidic material into the upper and/or adjustable expansion mandrel and/or by impacting the float shoe 28 on the bottom of the wellbore 30. After expanding the upper adjustable expansion mandrel 202 to the larger dimension, expansion surfaces 202a are defined on the upper adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12 In an exemplary embodiment, the expansion surfaces 202a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 20, the upper adjustable expansion mandrel 202 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion 12b of the tubular member 12 above the portion 12a of the tubular member. In an exemplary embodiment, the inside diameter of the radially expanded and plastically deformed portion 12a of the tubular member 12 is greater than the inside diameter of the radially expanded and plastically deformed portion 12b of the tubular member. In an exemplary embodiment, during the upward displacement of the upper adjustable

expansion mandrel 202, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore 30. In an exemplary embodiment, the interface between the expansion surfaces 202a of the upper adjustable expansion mandrel 202 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the upper adjustable expansion mandrel and the tubular member.

As illustrated in Fig. 21, the locking device 16 is then disengaged from the tubular member 12, and the tubular member 12 is supported by the upper adjustable expansion mandrel 202 The tubular support member 14, the locking device 16, the tubular support member 18, and the actuator 20 are then displaced upwardly relative to the upper adjustable expansion mandrel 202 and the tubular member 12.

As illustrated in Fig. 22, the locking device 16 then engages the tubular member 12 to maintain the tubular member in a stationary position relative to the tubular support member 14, and the upper adjustable expansion mandrel 202 is displaced upwardly relative by the actuator 20 to radially expand and plastically deform the portion 12b of the tubular member.

In an exemplary embodiment, the operations of Figs. 21 and 22 are then repeated until the remaining length of the portion 12b of the tubular member 12 is radially expanded and plastically deformed by the upper adjustable expansion mandrel 202. In several alternative embodiments, the upper adjustable expansion mandrel 202 may be collapsed to the smaller dimension prior to the further, or complete, radial expansion and plastic deformation of the tubular member 12.

Referring to Fig. 23, in an exemplary embodiment, the method and apparatus of one or more of Figs. 1-22 are repeated to provide a mono diameter wellbore casing 300 within a borehole 302 that traverses a subterranean formation 304 by successively overlapping and radially expanding and plastically deforming wellbore casing 306a-306d within the wellbore. In this manner, a wellbore casing 300 is provided that

defines an interior passage having a substantially constant cross sectional area throughout its length. In several alternative embodiments, the cross section of the wellbore casing 300 may be, for example, square, rectangular, elliptical, oval, circular and/or faceted.

Referring to Figs 24a-24k, an exemplary embodiment of an apparatus 400 for radially expanding and plastically deforming a tubular member includes a tubular support member 402 that defines a longitudinal passage 402a that is threadably coupled to and received within an end of a tool joint adaptor 404 that defines a longitudinal passage 404a and radial passages 404b and 404c.

The other end of the tool joint adaptor 404 receives and is threadably coupled to an end of a gripper upper mandrel 406 that defines a longitudinal passage 406a, external radial mounting holes, 406b and 406c, an external annular recess 406d, an external annular recess 406e, hydraulic port 406f, an internal annular recess 406g, hydraulic port 406h, external radial mounting holes, 406i and 406j, and includes a flange 406k, and a flange 406l. Torsional locking pins, 408a and 408b, are coupled to the external radial mounting holes 406b and 406c, respectively, of the gripper upper mandrel 406 and received within the radial passages, 404b and 404c, respectively, of the tool joint adaptor 404.

A spring retainer sleeve 410 that includes a flange 410a receives and is threadably coupled to the gripper upper mandrel 406 between an end face of the tool joint adaptor 404 and the flange 406k of the gripper upper mandrel. A bypass valve body 412 receives and is movably coupled to the gripper upper mandrel 406 that defines radial passages, 412a and 412b, and an internal annular recess 412c includes a flange 412d.

An end of a spring cover 414 receives and is movably coupled to the spring retainer sleeve 410 that defines an internal annular recess 414a. The other end of the spring cover 414 receives and is threadably coupled to an end of the bypass valve body 412. A spring guide 416, a spring 418, and a spring guide 420 are positioned within an annular chamber 422 defined between the spring cover 414 and the flange 406k of the gripper upper mandrel 406. Furthermore, an end of the spring guide 416 abuts an end face of the spring retainer sleeve 410.

Casing gripper locking dogs, 424a and 424b, are received and pivotally mounted within the radial passages, 412a and 412b, respectively, of the bypass valve body 412. An end of each of the casing gripper locking dogs, 424a and 424b, engage and are received within the outer annular recess 406d of the gripper upper mandrel 406. An end of a debris trap 426 receives and is threadably coupled to an end of the bypass valve body 412, and the other end of the debris trap receives and is movably coupled to the flange 406l of the gripper upper mandrel 406.

An end of a gripper body 428 receives and is threadably coupled to an end of the gripper upper mandrel 406 that defines a longitudinal passage 428a, radial passages, 428b and 428c, radial slip mounting passages, 428d-428m, and radial passages, 428n and 428o, includes a flange 428p

Hydraulic slip pistons 432a-432j are movably mounted with the radial slip mounting passages 428d-428m, respectively, for movement in the radial direction. Retainers 434a-434j are coupled to the exterior of the flange 428p of the gripper body 428 for limiting the outward radial movement of the hydraulic slip pistons 432a-432j, respectively, and springs 436a-436j are positioned within the radial slip mounting passages, 428d-428m, respectively, of the gripper body between the hydraulic slip pistons, 432a-432j, and the retainers, 434a-434j, respectively. During operation of the apparatus 400, pressurization of the radial slip mounting passages, 428d-428m, displaces the hydraulic slip pistons, 432a-432j, respectively, radially outwardly and compresses the springs, 436a-436j, respectively, and during depressurization of the radial slip mounting passages, 428d-428m, springs, 436a-436j, respectively, displace the hydraulic slip pistons, 432a-432j, inwardly. In an exemplary embodiment, displacement of the hydraulic slip pistons 432a-432j radially outwardly permits at least portions of the hydraulic slip pistons to engage and grip an outer tubular member.

Torsional locking pins, 438a and 438b, are coupled to the external radial mounting holes, 406i and 406j, respectively, of the gripper upper mandrel 406 and received within the radial passages, 428b and 428c, respectively, of the gripper body 428.

An end of a gripper body 440 receives and is threadably coupled to an end of the gripper body 428 that defines a longitudinal passage 440a, radial passages, 440b and 440c, radial slip mounting passages, 440d-440m, and radial passages, 440n and 440o, includes a flange 440p.

Hydraulic slip pistons 442a-442j are movably mounted with the radial slip mounting passages 440d-440m, respectively, for movement in the radial direction. Retainers 444a-444j are coupled to the exterior of the flange 440p of the gripper body 440 for limiting the outward radial movement of the hydraulic slip pistons 442a-442j, respectively, and springs 446a-446j are positioned within the radial slip mounting passages, 440d-440m, respectively, of the gripper body between the hydraulic slip pistons, 442a-442j, and the retainers, 444a-444j, respectively. During operation of the apparatus 400, pressurization of the radial slip mounting passages, 440d-440m, displaces the hydraulic slip pistons, 442a-442j, respectively, radially outwardly and compresses the springs, 446a-446j, respectively, and during depressurization of the radial slip mounting passages, 440d-440m, the springs, 446a-446j, respectively, displace the hydraulic slip pistons, 442a-442j, radially inward. In an exemplary embodiment, displacement of the hydraulic slip pistons 442a-442j radially outwardly permits at least portions of the hydraulic slip pistons to engage and grip an outer tubular member.

Torsional locking pins, 448a and 448b, are coupled to the external radial mounting holes, 428n and 428o, respectively, of the gripper body 428 and received within the radial passages, 440b and 440c, respectively, of the gripper body 440

An end of a tool joint adaptor 450 that defines a longitudinal passage 450a, radial passages, 450b and 450c, and an inner annular recess 450d, receives and is threadably coupled to an end of the gripper body 440. Torsional locking pins, 452a and 452b, are coupled to the external radial mounting holes, 440n and 440o, respectively, of the gripper body 428 and received within the radial passages, 450b and 450c, respectively, of the tool joint adaptor 450.

A bypass tube 454 that defines a longitudinal passage 454a is received within the longitudinal passages, 406a, 428a, 440a, and 450a, of the gripper upper mandrel 406,

the gripper body 428, the gripper body 440, and the tool joint adaptor 450, respectively, is coupled to the recess 406g of the gripper upper mandrel at one end and is coupled to the recess 450d of the tool joint adaptor at the other end.

An end of a cross over adaptor 456 that defines a longitudinal passage 456a receives and is threadably coupled to an end of the tool joint adaptor 450. The other end of the cross over adaptor 456 is received within and is coupled to an end of a tool joint adaptor 458 that defines a longitudinal passage 458a and external radial mounting holes, 458b and 458c.

An end of a positive casing locking body 460 that defines a tapered longitudinal passage 460a and radial passages, 460b and 460c, receives and is threadably coupled to the other end of the tool joint adaptor 458 Torsional locking pins, 462a and 462b, are coupled to the external radial mounting holes, 458b and 458c, respectively, of the tool joint adaptor 458 and received within the radial passages, 460b and 460c, respectively, of the positive casing locking body 460.

An end of a positive casing locking dog 464 mates with, is received within, and is coupled to the other end of the positive casing locking body 460 that includes internal flanges, 464a and 464b, and an external flange 464c. In an exemplary embodiment, the external flange 464c of the positive casing locking dog 464 includes an ribbed external surface 464d that engages and locks onto a ribbed internal surface 466a of a positive casing locking collar 466.

One end of the positive casing locking collar 466 is threadably coupled to a casing 468 and the other end of the positive casing locking collar is threadably coupled to a casing 470 that defines radial mounting holes, 470a and 470b, at a lower end thereof. In this manner, the casings, 468 and 470, are also engaged by and locked onto the positive casing locking dog 464.

The other end of the positive casing locking dog 464 mates with, is received within, and is coupled to an end of a positive casing locking body 472 that defines a tapered longitudinal passage 472a and radial passages, 472b and 472c. The other end of the positive casing locking body 472 receives, mates with, and is coupled to an end of a

casing lock barrel adaptor 474 that defines external radial mounting holes, 474a and 474b, and external radial mounting holes, 474c and 474d. Torsional locking pins, 475a and 475b, are coupled to the external radial mounting holes, 474a and 474b, respectively, of the casing lock barrel adaptor 474 and received within the radial passages, 472b and 472c, respectively, of the positive casing locking body 472.

An end of a positive casing lock releasing mandrel 476 that defines a longitudinal passage 476a, an external annular recess 476b, an external annular recess 476c, an external annular recess 476d, and an external annular recessed end portion 476e, is received within and movably coupled to an end of the tool joint adaptor 458. The middle portion of the positive casing lock releasing mandrel 476 is received within and mates with the internal flanges, 464a and 464b, of the positive casing locking dogs 464. The other end of the positive casing lock releasing mandrel 476 is received within and is movably coupled to the end of the casing lock barrel adaptor 474, and the external annular recessed portion 476e of the positive casing lock releasing mandrel is threadably coupled to and received within an end of a positive casing lock lower mandrel 478 that defines a longitudinal passage 478a, external radial mounting holes, 478b and 478c, and an external annular recessed end portion 478d.

A shear pin ring 480 that defines radial passages, 480a and 480b, receives and mates with the positive casing lock lower mandrel 478. Shear pins, 482a and 482b, are coupled to the external radial mounting holes, 478b and 478c, respectively, of the positive casing lock lower mandrel 478 and are received within the radial passages, 480a and 480b, respectively, of the shear pin ring 480.

An end of an actuator barrel 484 that defines a longitudinal passage 484a, radial passages, 484b and 484c, and radial passages, 484d and 484e, is threadably coupled to an end of the casing lock barrel adaptor 474. Torsional locking pins, 486a and 486b, are coupled to the external radial mounting holes, 474c and 474d, respectively, of the casing lock barrel adaptor and are received within the radial passages, 484b and 484c, respectively, of the actuator barrel.

The other end of the actuator barrel 484 is threadably coupled to an end of a barrel connector 486 that defines an internal annular recess 486a, external radial mounting

holes, 486b and 486c, radial passages, 486d and 486e, and external radial mounting holes, 486f and 486g. A sealing cartridge 488 is received within and coupled to the internal annular recess 486a of the barrel connector 486 for fluidicly sealing the interface between the barrel connector and the sealing cartridge Torsional locking pins, 490a and 490b, are coupled to and mounted within the external radial mounting holes, 486b and 486c, respectively, of the barrel connector 486 and received within the radial passages, 484d and 484e, of the actuator barrel 484

The other end of the barrel connector 486 is threadably coupled to an end of an actuator barrel 492 that defines a longitudinal passage 492a, radial passages, 492b and 492c, and radial passages, 492d and 492e. Torsional locking pins, 494a and 494b, are coupled to and mounted within the external radial mounting holes, 486f and 486g, respectively, of the barrel connector 486 and received within the radial passages, 492b and 492c, of the actuator barrel 492. The other end of the actuator barrel 492 is threadably coupled to an end of a barrel connector 496 that defines an internal annular recess 496a, external radial mounting holes, 496b and 496c, radial passages, 496d and 496e, and external radial mounting holes, 496f and 496g. A sealing cartridge 498 is received within and coupled to the internal annular recess 496a of the barrel connector 496 for fluidicly sealing the interface between the barrel connector and the sealing cartridge. Torsional locking pins, 500a and 500b, are coupled to and mounted within the external radial mounting holes, 496b and 496c, respectively, of the barrel connector 496 and received within the radial passages, 492d and 492e, of the actuator barrel 492.

The end of the barrel connector 496 is threadably coupled to an end of an actuator barrel 502 that defines a longitudinal passage 502a, radial passages, 502b and 502c, and radial passages, 502d and 502e. Torsional locking pins, 504a and 504b, are coupled to and mounted within the external radial mounting holes, 496f and 496g, respectively, of the barrel connector 496 and received within the radial passages, 502b and 502c, of the actuator barrel 502. The other end of the actuator barrel 502 is threadably coupled to an end of a barrel connector 506 that defines an internal annular recess 506a, external radial mounting holes, 506b and 506c, radial passages, 506d and 506e, and external radial mounting holes, 506f and 506g. Torsional locking pins, 508a and 508b, are coupled to and mounted within the external radial mounting holes,

506b and 506c, respectively, of the barrel connector 506 and received within the radial passages, 502d and 502e, of the actuator barrel 502 A sealing cartridge 510 is received within and coupled to the internal annular recess 506a of the barrel connector 506 for fluidicly sealing the interface between the barrel connector and the sealing cartridge.

The other end of the barrel connector 506 is threadably coupled to an end of an actuator barrel 512 that defines a longitudinal passage 512a, radial passages, 512b and 512c, and radial passages, 512d and 512e. Torsional locking pins, 514a and 514b, are coupled to and mounted within the external radial mounting holes, 506f and 506g, respectively, of the barrel connector 506 and received within the radial passages, 512b and 512c, of the actuator barrel 512. The other end of the actuator barrel 512 is threadably coupled to an end of a lower stop 516 that defines an internal annular recess 516a, external radial mounting holes, 516b and 516c, and an internal annular recess 516d that includes one or more circumferentially spaced apart locking teeth 516e at one end and one or more circumferentially spaced apart locking teeth 516f at the other end. A sealing cartridge 518 is received within and coupled to the internal annular recess 516a of the barrel connector 516 for fluidicly sealin the interface between the barrel connector and the sealing cartridge. Torsional locking pins, 520a and 520b, are coupled to and mounted within the external radial mounting holes, 516b and 516c, respectively, of the barrel connector 516 and received within the radial passages, 512d and 512e, of the actuator barrel 512.

A connector tube 522 that defines a longitudinal passage 522a is received within and sealingly and movably engages the interior surface of the sealing cartridge 488 mounted within the annular recess 486a of the barrel connector 486. In this manner, during longitudinal displacement of the connector tube 522 relative to the barrel connector 486, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector An end of the connector tube 522 is received within and is threadably coupled to an end of dart/ball guide 524 that defines a tapered passage 524a at the other end.

The other end of the connector tube 522 is received within and threadably coupled to an end of a piston 526 that defines a longitudinal passage 526a and radial passages,

526b and 526c, that includes a flange 526d at one end. A sealing cartridge 528 is mounted onto and sealingly coupled to the exterior of the piston 526 proximate the flange 526d. The sealing cartridge 528 also mates with and sealingly engages the interior surface of the actuator barrel 492 In this manner, during longitudinal displacement of the piston 526 relative to the actuator barrel 492, a fluidic seal is maintained between the exterior surface of the piston and the interior surface of the actuator barrel

The other end of the piston 526 receives and is threadably coupled to an end of a connector tube 529 that defines a longitudinal passage 528a. The connector tube 529 is received within and sealingly and movably engages the interior surface of the sealing cartridge 498 mounted within the annular recess 496a of the barrel connector 496. In this manner, during longitudinal displacement of the connector tube 529 relative to the barrel connector 496, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector.

The other end of the connector tube 529 is received within and threadably coupled to an end of a piston 530 that defines a longitudinal passage 530a and radial passages, 530b and 530c, that includes a flange 530d at one end. A sealing cartridge 532 is mounted onto and sealingly coupled to the exterior of the piston 530 proximate the flange 530d The sealing cartridge 532 also mates with and sealingly engages the interior surface of the actuator barrel 502. In this manner, during longitudinal displacement of the piston 530 relative to the actuator barrel 502, a fluidic seal is maintained between the exterior surface of the piston and the interior surface of the actuator barrel.

The other end of the piston 530 receives and is threadably coupled to an end of a connector tube 534 that defines a longitudinal passage 534a. The connector tube 534 is received within and sealingly and movably engages the interior surface of the sealing cartridge 510 mounted within the annular recess 506a of the barrel connector 506. In this manner, during longitudinal displacement of the connector tube 534 relative to the barrel connector 506, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector.

The other end of the connector tube 534 is received within and threadably coupled to an end of a piston 536 that defines a longitudinal passage 536a, radial passages, 536b and 536c, and external radial mounting holes, 536d and 536e, that includes a flange 536f at one end. A sealing cartridge 538 is mounted onto and sealingly coupled to the exterior of the piston 536 proximate the flange 536d The sealing cartridge 538 also mates with and sealingly engages the interior surface of the actuator barrel 512. In this manner, during longitudinal displacement of the piston 536 relative to the actuator barrel 512, a fluidic seal is maintained between the exterior surface of the piston and the interior surface of the actuator barrel.

The other end of the piston 536 is received within and threadably coupled to an end of a lock nut 540 that defines radial passages, 540a and 540b, and includes one or more circumferentially spaced apart locking teeth 540c at the other end for engaging the circumferentially spaced apart locking teeth 516e of the lower stop 516

A threaded bushing 542 is received within and threadably coupled to the circumferentially spaced apart locking teeth 540c of the lock nut 540. An end of a connector tube 544 that defines a longitudinal passage 544a is received within and is threadably coupled to the threaded bushing 542. A sealing sleeve 546 is received within and is threadably coupled to adjacent ends of the piston 536 and the connector tube 544 for fluidicly sealing the interface between the end of the piston and the end of the connector tube. Torsional locking pins, 548a and 548b, are mounted within and coupled to the external radial mounting holes, 536d and 536e, respectively, of the piston 536 that are received within the radial passages, 540a and 540b, of the stop nut 540.

The connector tube 544 is received within and sealingly and movably engages the interior surface of the sealing cartridge 518 mounted within the annular recess 516a of the barrel connector 516. In this manner, during longitudinal displacement of the connector tube 544 relative to the barrel connector 516, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector.

The other end of the connector tube 544 is received within and is threadably coupled to a threaded bushing 550. The threaded bushing 550 is received within and threadably coupled to a lock nut 552 that defines radial passages, 552a and 552b, and includes one or more circumferentially spaced apart locking teeth 552c at one end for engaging the circumferentially spaced apart locking teeth 516f of the lower stop 516. The other end of the lock nut 552 receives and is threadably coupled to an end of tool joint adaptor 554 that defines a longitudinal passage 554a, external radial mounting holes, 554b and 554c. Torsional locking pins, 556a and 556b, are mounted within and coupled to the external radial mounting holes, 554b and 554c, respectively, of the tool joint adaptor 554 that are received within the radial passages, 552a and 552b, of the stop nut 552. A sealing sleeve 558 is received within and is threadably coupled to adjacent ends of the connector tube 544 and the tool joint adaptor 554 for fluidicly sealing the interface between the end of the connector tube and the end of the tool joint adaptor.

The other end of the tool joint adaptor 554 is received within and threadably coupled to an end of a tool joint adaptor 560 that defines a longitudinal passage 560a A torsion plate 562 is received within and threadably coupled to the other end of the tool joint adaptor 560 that defines a longitudinal passage 562a and includes one or more circumferentially spaced apart locking teeth 562b at one end. An end of an upper bushing 564 is also received within and threadably coupled to the other end of the tool joint adaptor 560 proximate the torsion plate 562 that receives and is threadably coupled to an end of a cup mandrel 566 that defines a longitudinal passage 566a and includes a plurality of circumferentially spaced apart locking teeth 566b at one end for engaging the circumferentially spaced apart locking teeth 562b of the torsion plate 562. The end of the cup mandrel 566 is further positioned proximate an end face of the torsion plate 562.

A thimble 568 is mounted on and is threadably coupled to the cup mandrel 566 proximate an end face of the upper bushing 564. An inner thimble 570 is mounted on and is threadably coupled to the cup mandrel 566 proximate an end of the thimble 568, and one end of the inner thimble is received within and mates with the end of the thimble. A resilient packer cup 572 is mounted on and sealingly engages the cup mandrel 566 proximate an end of the inner thimble 570, and one end of the packer cup

is received within and mates with the end of the inner thimble. A packer cup backup ring 574 is mounted on the inner thimble 570 proximate an end face of the thimble 568, and an end of the packer cup backup ring 574 receives and mates with the packer cup 572 A spacer 576 is mounted on and threadably engages the cup mandrel 566 proximate an end face of the packer cup 572.

A thimble 578 is mounted on and is threadably coupled to the cup mandrel 566 proximate an end of the spacer 576. An inner thimble 580 is mounted on and is threadably coupled to the cup mandrel 566 proximate an end of the thimble 578, and one end of the inner thimble is received within and mates with the end of the thimble. A resilient packer cup 582 is mounted on and sealingly engages the cup mandrel 566 proximate an end of the inner thimble 580, and one end of the packer cup is received within and mates with the end of the inner thimble. A packer cup backup ring 584 is mounted on the inner thimble 580 proximate an end face of the thimble 578, and an end of the packer cup backup ring 584 receives and mates with the packer cup 582. An adjustable spacer 586 is mounted on and threadably engages the cup mandrel 566 proximate an end face of the packer cup 582.

An end of a cone mandrel 588 that defines a longitudinal passage 588a, an external lock ring groove 588b, an external lock ring groove 588c, an external lock ring groove 588d, an external lock ring groove 588e, radial passages, 588f and 588g, and locking dog grooves 588h receives and is threadably coupled to an end of the cup mandrel 566. A shear pin bushing 590 that defines external radial mounting holes, 590a and 590b, at one end and an annular recess 590c at another end and includes circumferentially spaced apart locking teeth 590d at the other end is mounted on and is movably coupled to the cone mandrel 588. Torsional shear pins, 592a and 592b, are mounted within and coupled to the external radial mounting holes, 590a and 590b, respectively, of the shear pin bushing 590 and received within the radial passages, 470a and 470b, respectively, of the end of the casing 470 In this manner, torque loads may be transmitted between the casing 470 and the shear pin bushing 590. A resilient lock ring 594 is retained in the external lock ring groove 588b of the cone mandrel and received within the internal annular recess 590c at the end of the shear pin bushing 590.

Referring to Figs. 24j, 25a, and 25b, an upper cone retainer 596 receives, mates with, and is coupled to the end of the shear pin bushing 590 that includes an internal flange 596a and an internal upper pivot point flange 596b. An end of an upper cam 598 includes a tubular base 598a that mates with, receives, and is movably coupled to the cone mandrel 588. The tubular base 598a of the upper cam 598 further includes an external flange 598b that is received within and mates with the upper cone retainer 596 proximate the internal flange 596a of the upper cone retainer and a plurality of circumferentially spaced apart locking teeth 598c that engage the circumferentially spaced apart locking teeth 590d of the end of the shear pin bushing 590. In this manner, the upper cam 598 is retained within the upper cone retainer 596 and torque loads may be transmitted between the upper cam and the shear pin bushing 590.

Referring to Figs. 25b and 25c, the upper cam 598 further includes a plurality of circumferentially spaced apart cam arms 598d that extend from the tubular base 598a in the longitudinal direction that mate with, receive, and are movably coupled to the cone mandrel 588. Each cam arm 598d includes an inner surface 598da that is an arcuate cylindrical segment, a first outer surface 598db that is an arcuate cylindrical segment, a second outer surface 598dc that is an arcuate conical segment, and a third outer surface 598dd that is an arcuate cylindrical segment. In an exemplary embodiment, each of the cam arms 598d are identical.

Referring to Figs. 24j, 25a, and 25d, a plurality of circumferentialy spaced apart upper cone segments 600 are interleaved among the cam arms 598d of the upper cam 598. In an exemplary embodiment, each upper cone segment 600 includes a first outer surface 600a that defines a hinge groove 600b, a second outer surface 600c, a third outer surface 600d, a fourth outer surface 600e, a first inner surface 600f, a second inner surface 600g, a third inner surface 600h, and a fourth inner surface 600i. In an exemplary embodiment, the first outer surface 600a, the second outer surface 600c, the fourth outer surface 600e, the first inner surface 600f, the second inner surface 600g, and the fourth inner surface 600i are arcuate cylindrical segments. In an exemplary embodiment, the third outer surface 600d is an arcuate spherical segment. In an exemplary embodiment, the third inner surface 600h is an arcuate conical segment. In an exemplary embodiment, each of the upper cone segments 600 are identical. In an exemplary embodiment, the hinge grooves 600b of the upper cone

segments 600 receive and mate with the pivot point 596b of the upper cone retainer 596 In this manner, the upper cone segments 600 are pivotally coupled to the upper cone retainer 596.

Referring to Figs. 24j, 25a, and 25e, a plurality of circumferentially spaced apart lower cone segments 602 overlap with and are interleaved among the upper cone segments 600. In an exemplary embodiment, each lower cone segment 602 includes a first outer surface 602a that defines a hinge groove 602b, a second outer surface 602c, a third outer surface 602d, a fourth outer surface 602e, a first inner surface 602f, a second inner surface 602g, a third inner surface 602h, and a fourth inner surface 602i In an exemplary embodiment, the first outer surface 602a, the second outer surface 602c, the fourth outer surface 602e, the first inner surface 602f, the second inner surface 602g, and the fourth inner surface 602i are arcuate cylindrical segments. In an exemplary embodiment, the third outer surface 602d is an arcuate spherical segment. In an exemplary embodiment, the third inner surface 602h is an arcuate conical segment. In an exemplary embodiment, each of the lower cone segments 602 are identical.

Referring to Figs. 24j, 25a, 25b, and 25f, a plurality of circumferentially spaced apart cam arms 604a that extend in the longitudinal direction from a tubular base 604b of a lower cam 604 overlap and are interleaved among the circumferentially spaced apart cam arms 598d of the upper cam 598 and mate with, receive, and are movably coupled to the cone mandrel 588. The tubular base 604b of the lower cam 604 mates with, receives, and is movably coupled to the cone mandrel 588 and includes an external flange 604c and a plurality of circumferentially spaced apart locking teeth 604d. Each cam arm 604a includes an inner surface 604aa that is an arcuate cylindrical segment, a first outer surface 604ab that is an arcuate cylindrical segment, a second outer surface 604ac that is an arcuate conical segment, and a third outer surface 604ad that is an arcuate cylindrical segment. In an exemplary embodiment, each of the cam arms 604a are identical.

An end of a lower cone retainer 606 includes an inner pivot point flange 606a that mates with and is received within the hinge grooves 602b of the lower cone segments 602. In this manner, the lower cone segments 602 are pivotally coupled to the lower

cone retainer 606. The lower cone retainer 606 further includes an inner flange 606b that mates with and retains the external flange 604c of the lower cam 604. In this manner, the lower cam 604 is retained within the lower cone retainer 606.

The other end of the lower cone retainer 606 receives and is threadably coupled to an end of a release housing 608 that defines a radial passage 608a at another end and includes a plurality of circumferentially spaced apart locking teeth 608b at the end of the release housing for engaging the circumferentially spaced apart locking teeth 604d of the lower cam 604 In this manner, torque loads may be transmitted between the release housing 608 and the lower cam 604. An end of a lower mandrel 610 that defines a longitudinal passage 610a, an external radial mounting hole 610b, and radial passages 610c is received within, mates with, and is movably coupled to the other end of the release housing 608. A torsion locking pin 612 is mounted within and coupled to the external radial mounting hole 610b of the lower mandrel 610 and received within the radial passage 608a of the release housing 608. In this manner, longitudinal and torque loads may be transmitted between the release housing 608 and the lower mandrel 610.

An end of a locking dog retainer sleeve 614 that defines an inner annular recess 614a at one end and includes a plurality of circumferentially spaced apart locking teeth 614b at one end for engaging the locking teeth 604d of the lower cam 604 is received within and threadably coupled to an end of the lower mandrel 610. The locking dog retainer sleeve 614 is also positioned between and movably coupled to the release housing 608 and the cone mandrel 588. Locking dogs 616 are received within the inner annular recess 614a of the locking dog retainer sleeve 614 that releasably engage the locking dog grooves 588h provided in the exterior surface of the cone mandrel 588. In this manner, the locking dogs 616 releasably limit the longitudinal displacement of the lower cone segments 602, lower cam 604, and the lower cone retainer 606 relative to the cone mandrel 588.

A locking ring retainer 618 is received within and is threadably coupled to an end of the lower mandrel 610 that defines an inner annular recess 618a for retaining a resilient locking ring 620 within the lock ring groove 588d of the cone mandrel 588. The locking ring retainer 618 further mates with and is movably coupled to the cone mandrel 588.

An end of an emergency release sleeve 622 that defines radial passages 622a, an outer annular recess 622b, and a longitudinal passage 622c is received within and is threadably coupled to an end of the lower mandrel 610. The emergency release sleeve 622 is also received within, mates with, and slidably and sealingly engages an end of the cone mandrel 588.

An end of a pressure balance piston 624 is received within, mates with, and slidably and sealingly engages the end of the lower mandrel 610 and receives, mates with, and is threadably coupled to an end of the cone mandrel 588. The other end of the pressure balance piston 624 receives, mates with, and slidably and sealingly engages the emergency release sleeve 622.

An end of a bypass valve operating probe 626 that defines a longitudinal passage 626a is received within and is threadably coupled to another end of the lower mandrel 610. An end of an expansion cone mandrel 628 that defines radial passages 628a receives and is threadably coupled to the other end of the lower mandrel 610. A sealing sleeve expansion cone 630 is slidably coupled to the other end of the expansion cone mandrel 628 that includes an outer tapered expansion surface 630a. A guide 632 is releasably coupled to another end of the expansion cone mandrel 628 by a retaining collet 634.

An end of an expandable sealing sleeve 636 receives and is mounted on the sealing sleeve expansion cone 630 and the guide 632 The other end of the expandable sealing sleeve 636 receives and is threadably coupled to an end of a bypass valve body 638 that defines radial passages, 638a and 638b. An elastomeric coating 640 is coupled to the exterior of at least a portion of the expandable sealing sleeve 636. An end of a probe guide 642 that defines an inner annular recess 642a is received within and is threadably coupled to an end of the bypass valve body 638 and receives and mates with an end of the bypass valve operating probe 626.

A bypass valve 644 that defines a longitudinal passage 644a and radial passages, 644b and 644c, and includes a collet locking member 644d at one end for releasably engaging an end of the bypass valve operating probe 626 is received within, mates with, and slidably and sealingly engages the bypass valve body 638. An end of a lower

mandrel 646 that defines a longitudinal passage 646a receives and is threadably coupled to an end of the bypass valve body 638.

An end of a dart guide sleeve 648 that defines a longitudinal passage 648a is received within and is coupled to an end of the bypass valve body 638 and the other end of the dart guide sleeve 648 is received within and is coupled with the lower mandrel 646. An end of a differential piston 650 that includes an inner flange 650a at another end receives and is coupled to an end of the lower mandrel 646 by one or more shear pins 652. An end of a float valve assembly 654 including a float valve 654a, a valve guard 654b, and a guide nose 654c receives and is threadably coupled to an end of the lower mandrel 646. A plurality of circumferentially spaced apart locking dogs 656 are pivotally coupled to the inner flange 650a of the differential piston 650 and are further supported by an end of the float valve assembly 654.

As illustrated in Figs. 24a-24k, in an exemplary embodiment, during operation of the apparatus 400, the apparatus is initially positioned within a preexisting structure 700 such as, for example, a wellbore that traverses a subterranean formation. In several alternative embodiments, the wellbore 7·0 may have any inclination from vertical to horizontal. Furthermore, in several alternative embodiments, the wellbore 700 may also include one or more preexisting wellbore casings, or other well construction elements, coupled to the wellbore. During the positioning of the apparatus 400 within the wellbore 700, the casings, 468 and 470, are supported by the positive casing locking dog 464 and the torsional shear pins, 592a and 592b. In this manner, axial and torque loads may be transmitted between the casings, 468 and 470, and the tubular support member 402.

In an exemplary embodiment, as illustrated in Fig. 25h, prior to the assembly of the apparatus 400, the force of the spring 418 applies a sufficient downward longitudinal force to position the ends of the casing gripper locking dogs, 424a and 424b, between the outer annular recesses, 406d and 406e, of the gripper upper mandrel 406 thereby placing the bypass valve body 412 in a neutral position. In an exemplary embodiment, when the apparatus 400 is assembled by inserting the apparatus into the casing 468, the ends of the casing gripper locking dogs, 424a and 424b, impact the upper end of the casing 468 and are thereby displaced, along with the bypass valve body 412,

upwardly relative to the gripper upper mandrel 406 until the ends of the casing gripper locking dogs pivot radially inwardly into engagement with the outer annular recess 406d of the gripper upper mandrel. In this manner, the bypass valve body 412 is positioned in an inactive position, as illustrated in Fig. 24a, that fluidicly decouples the casing gripper hydraulic ports, 406f and 406h. The upward displacement of the bypass valve body 412 relative to the gripper upper mandrel 406 further compresses the spring 418. The bypass valve body 412 is then maintained in the inactive position due to the placement of the casing gripper locking dogs, 424a and 424b, within the casing 468 thereby preventing the ends of the casing gripper locking dogs from pivoting radially outward out of engagement with the outer annular recess 406d.

Referring to Figs. 26a-26k, when the apparatus 400 is positioned at a desired predetermined position within the wellbore 700, a fluidic material 702 is injected into the apparatus through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, 644a, and 646a and out of the apparatus through the float valve 654a. In this manner the proper operation of the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, 644a, and 646a and the float valve 654a may be tested. A dart 704 is then injected into the apparatus with the fluidic material 702 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, and 644a until the dart is positioned and seated in the passage 646a of the lower mandrel 646. As a result of the positioning of the dart 704 in the passage 646a of the lower mandrel 646, the passage of the lower mandrel is thereby closed.

The fluidic material 702 is then injected into the apparatus thereby increasing the operating pressure within the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, and 644a. Furthermore, the continued injection of the fluidic material 702 into the apparatus 400 also causes the fluidic material 702 to pass through the radial passages, 526b and 526c, 530b and 530c, and 536b and 536c, of the piston 526, 530, and 536, respectively, into an annular pressure chamber 706 defined between the actuator barrel 492 and the connector tube 529, an annular pressure chamber 708 defined

between the actuator barrel 502 and the connector tube 534, and an annular pressure chamber 710 defined between the actuator barrel 512 and the connector tube 544.

The pressurization of the annular pressure chambers, 706, 708, and 710 then cause the pistons 526, 530, and 536 to be displaced upwardly relative to the casing 470. As a result, the connector tube 529, the connector tube 534, the connector tube 544, the threaded bushing 550, the lock nut 552, the tool joint adaptor 554, the sealing sleeve 558, the tool joint adaptor 560, the torsion plate 562, the upper bushing 564, the cup mandrel 566, the thimble 568, the inner thimble 570, the packer cup 572, the backup ring 574, the spacer 576, the thimble 578, the inner thimble 580, the packer cup 582, the backup ring 584, the spacer 586, and the cone mandrel 588 are displaced upwardly relative to the casing 470, the shear pin bushing 590, the locking ring 594, the upper cone retainer 596, the upper cam 598, and the upper cone segments 600.

As a result, as illustrated in Figs. 26j, 27a, and 27b, the shear pin bushing 590, the locking ring 594, the upper cone retainer 596, the upper cam 598, and the upper cone segments 600 are displaced downwardly relative to the cone mandrel 588, the lower cone segments 602, and the lower cam 604 thereby driving the upper cone segments 600 onto and up the cam arms 604a of the lower cam 604, and driving the lower cone segments 602 onto and up the cam arms 598d of the upper cam 598. During the outward radial displacement of the upper and lower cone segments, 600 and 602, the upper and cone segments translate towards one another in the longitudinal direction and also pivot about the pivot points, 596b and 606a, of the upper and lower cone retainers, 596 and 606, respectively.

As a result, a segmented expansion cone is formed that includes a substantially continuous outer arcuate spherical surface provided by the axially aligned and interleaved upper and lower expansion cone segments, 600 and 602. Furthermore, the resilient locking ring 594 is relocated from the lock ring groove 588b to the lock ring groove 588c thereby releasably locking the positions of the shear pin bushing 590, the locking ring 594, the upper cone retainer 596, the upper cam 598, and the upper cone segments 600 relative to the cone mandrel 588.

Referring to Figs. 28a to 28j, the continued injection of the fluidic material 702 into the apparatus 400 continues to pressurize annular pressure chambers, 706, 708, and 710. As a result, an upward axial force is applied to the shear pin bushing 590 that causes the torsional shear pins, 592a and 592b, to be sheared thereby decoupling the wellbore casing 470 from the shear pin bushing 590 and permitting the pistons 526, 530, and 536 to be further displaced upwardly relative to the casing 470. The further upward displacement of the pistons 526, 530, and 536 in turn displaces the cone mandrel 588, the upper cam 598, the upper cone segments 600, the lower cone segments 602, and the lower cam 604 upwardly relative to the casing 470 As a result, the segmented expansion cone provided by the interleaved and axially aligned upper and lower cone segments, 600 and 602, radially expands and plastically deforms a portion of the casing 470

Referring to Figs. 29a-29m, during the continued injection of the fluidic material 702, the segmented expansion cone provided by the interleaved and axially aligned upper and lower cone segments, 600 and 602, will continue to be displaced upwardly relative to the casing 470 thereby continuing to radially expand and plastically deform the casing until the locking dogs 656 engage and push on the lower end of the casing 470. When the locking dogs 656 engage and push on the lower end of the casing 470, the locking dogs 656, the float valve assembly 654, the differential piston 650, the dart guide sleeve 648, the lower mandrel 646, the bypass valve 644, the elastomeric coating 640, the bypass valve body 638, the expandable sealing sleeve 636, the retaining collet 634, the guide 632, the sealing sleeve expansion cone 630, the expansion cone mandrel 628, the bypass valve operating probe 626, the pressure balance piston 624, the emergency release sleeve 622, the resilient locking ring 620, the locking ring retainer 618, the locking dogs 616, the locking dog retainer sleeve 614, the torsion locking pin 612, the lower mandrel 610, the release housing 608, the lower cone retainer 606, the lower cam 604, and the lower cone segments 602 are displaced downwardly in the longitudinal direction relative to the cone mandrel 588. As a result, the upper cam 598 and the upper cone segments 600 are moved out of axial alignment with the lower cone segments 602 and the lower cam 604 thereby collapsing the segmented expansion cone. Furthermore, the locking ring 620 is moved from the lock ring groove 588d to the lock ring groove 588e thereby releasably fixing the new position of the lower cone segments 602 and the lower cam 604.

In particular, as illustrated in Fig. 30a, when a downward tensile longitudinal force is initially applied to the lower mandrel 610 relative to cone mandrel 588, the lower mandrel, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 when the applied tensile force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d. As illustrated in Fig. 30b, if the applied tensile force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d, the lower mandrel 610, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 thereby displacing the annular recess 614a of the locking dog retainer sleeve downwardly relative to the locking dogs 616. As a result, the locking dogs 616 are released from engagement with the locking dog grooves 588h of the cone mandrel 588 thereby permitting the lower cone segments 602, the lower cam 604, and the lower cone retainer 606 to be displaced downwardly relative to the cone mandrel 588

As illustrated in Fig. 30c, further downward displacement of the lower mandrel 610 then causes the torsion locking pin 612 to engage and displace the release housing 608 downwardly relative to the cone mandrel 588 thereby displacing the locking dogs 616, the lower cone retainer 606, the lower cam 604, and the lower cam segments 602 downwardly relative to the cone mandrel. As a result, the lower cone segments 602 and the lower cam 604 are displaced downwardly out of axial alignment with the upper cam 598 and the upper cam segments 600 thereby collapsing the segmented expansion cone. Furthermore, the downward displacement of the locking dog retainer sleeve 614 also displaced the locking ring retainer 618 and the locking ring 620 downwardly relative to the cone mandrel 588 thereby relocating the locking ring from the lock ring groove 588d to the lock ring groove 588e. In this manner, the now position of the lower cone segments 602 and the lower cam 604 are thereby releasably fixed relative to the cam mandrel 588 by the locking ring 620.

The operations of Figs 30a-30c may be reversed, and the segmented expansion cone may again be expanded, by applying a upward compressive force to the lower mandrel 610 If the compressive force is sufficient, the locking ring 620 will be released from engagement with the lock ring groove 588e, thereby permitting the lower mandrel 610

and the locking dog retainer 614 to be displaced upwardly relative to the cone mandrel 588. As a result, the locking dog retainer 614 will engage and displace the locking dogs 616, the lower cam 604, the lower cone segments 602, the lower cone retainer 606, and the release housing 608 upwardly relative to the cone mandrel 588 thereby bringing the upper cam 598 and the upper cone segments 600 back into axial alignment with the lower cone segments 602 and the lower cam 604. As a result, the segmented expansion cone is once again expanded Once the segmented cone has been fully expanded, the locking dogs 616 will once again be positioned in alignment with the locking dog grooves 588h of the cone mandrel 588 and will thereby once again engage the locking dog grooves. The continued upward displacement of the lower mandrel 610 relative to cone mandrel 588 will thereby also upwardly displace the locking dog retainer 614 upwardly relative to the cone mandrel thereby once again capturing and restraining the locking dogs 616 within the annular recess 614a of the locking dog retainer. As a result, the new expansion position of the lower cone segments 602 and the lower cam 604 relative to the cone mandrel 588 will be releasably locked by the locking dogs 616. Furthermore, the locking ring 620 will also be relocated from engagement with the lock ring groove 588e to engagement with the lock ring groove 588d to thereby releasably lock the expanded segmented cone in the expanded position.

Referring to Figs. 31a-31n, the continued injection of the fluidic material 702 into the apparatus 400 continues to pressurize the piston chambers 706, 708, and 710 thereby further displacing the pistons upwardly 526, 530, and 536 upwardly relative to the support member 402. Because the engagement of the locking dogs 656 with the lower end of the casing 470 prevents float valve 654 from entering the casing, the continued upward displacement of the pistons 526, 530, and 536 relative to the support member 402 causes the bypass valve operating probe 626 to be displaced upwardly relative to the support member thereby disengaging the bypass valve operating probe from the probe guide 642, and also causes the sealing sleeve expansion cone 630 to be displaced upwardly relative to the expandable sealing sleeve 636 thereby radially expanding and plastically deforming the sealing sleeve 636 and the elastomeric coating 640 into sealing engagement with the interior surface of the lower end of the casing 470. As a result, the lower end of the casing 470 is fluidicly sealed by the combination of the sealing engagement of the sealing sleeve 636 and elastomeric coating 640 with

the interior surface of the lower end of the casing and the positioning the dart 704 within the passage 646a of the lower mandrel 646.

Continued injection of the fluidic material 702 into the apparatus 400 continues to pressurize the piston chambers 706, 708, and 710 until the pistons 536, 530 and 536 are displaced upwardly relative to the casing 470 to their maximum upward position relative to the support member 402. As a result, the dart ball guide 524 impacts the positive casing lock mandrel 478 with sufficient force to shear the shear pins, 428a and 428b, thereby decoupling the positive casing lock mandrel 478 from the casing lock barrel adaptor 474. The positive casing lock mandrel 478 is then displaced upwardly relative to the support member 402 which in turn displaces the positive casing lock releasing mandrel 476 upwardly relative to the positive casing locking dogs 464. As a result, the internal flanges, 464a and 464b, of the positive casing locking dogs are relocated into engagement with the annular recesses, 476c and 476d, respectively, of the positive casing lock releasing mandrel 476. The positive casing lock casing collar 466 is thereby released from engagement with the positive casing locking dogs 464 thereby releasing the casings 468 and 470 from engagement with the support member 402. As a result, the positions of the casings, 468 and 470, are no longer fixed relative to the support member 402.

Referring to Figs. 32a-32k, the injection of the fluidic material 702 is stopped and the support member 402 is then lowered into the wellbore 700 until the float valve assembly 654 impacts the bottom of the wellbore. The support member 402 is then further lowered into the wellbore 700, with the float valve assembly 654 resting on the bottom of the wellbore, until the bypass valve operating probe 626 impacts and displaces the bypass valve 644 downwardly relative to the bypass valve body 638 to fluidicly couple the passages, 638a and 644b, and the passages, 638b and 644c, and until sufficient upward compressive force has been applied to the lower mandrel 610 to re-expand the segmented expansion cone provided by the cone segments, 600 and 602. In an exemplary embodiment, the collet locking member 644d of the bypass valve 644 will also engage an end of the bypass valve operating probe 626.

In an exemplary embodiment, the support member 402 is lowered downwardly into the wellbore 700 such that sufficient upward compressive force is applied to the lower

mandrel 610 to release the locking ring 620 from engagement with the lock ring groove 588e, thereby permitting the lower mandrel 610 and the locking dog retainer 614 to be displaced upwardly relative to the cone mandrel 588. As a result, the locking dog retainer 614 will engage and displace the locking dogs 616, the lower cam 604, the lower cone segments 602, the lower cone retainer 606, and the release housing 608 upwardly relative to the cone mandrel 588 thereby bringing the upper cam 598 and the upper cone segments 600 back into axial alignment with the lower cone segments 602 and the lower cam 604. As a result, the segmented expansion cone is once again expanded. Once the segmented cone has been fully expanded, the locking dogs 616 will once again be positioned in alignment with the locking dog grooves 588h of the cone mandrel 588 and will thereby once again engage the locking dog grooves. The continued upward displacement of the lower mandrel 610 relative to cone mandrel 588 will thereby also upwardly displace the locking dog retainer 614 upwardly relative to the cone mandrel thereby once again capturing and restraining the locking dogs 616 within the annular recess 614a of the locking dog retainer As a result, the new expansion position of the lower cone segments 602 and the lower cam 604 relative to the cone mandrel 588 will be releasably locked by the locking dogs 616. Furthermore, the locking ring 620 will also be relocated from engagement with the lock ring groove 588e to engagement with the lock ring groove 588d to thereby releasably lock the expanded segmented cone in the expanded position.

A hardenable fluidic sealing material 712 may then be injected into the apparatus 400 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 522a, 526a, 529a, 530a, 534a, 536a, 544a, 554a, 566a, 588a, 622a, 610a, 626a, 638a, 638b, 644b, and 644c, and out of the apparatus through the circumferential gaps defined between the circumferentially spaced apart locking dogs 656 into the annulus between the casings 468 and 470 and the wellbore 700. In an exemplary embodiment, the hardenable fluidic sealing material 712 is a cement suitable for well construction. The hardenable fluidic sealing material 712 may then be allowed to cure before or after the further radial expansion and plastic deformation of the casings 468 and/or 470.

Referring to Figs. 33a-33p, after completing the injection of the fluidic material 712, the support member 402 is then lifted upwardly thereby displacing the bypass valve operating probe 626 and the bypass valve 644 upwardly to fluidicly decouple the

passages, 638a and 644b and 638b and 644c, until the collet locking member 644d of the bypass valve is decoupled from the bypass valve operating probe. The support member 402 is then further lifted upwardly until the segmented expansion cone, provided by the interleaved and axially aligned cone segments, 600 and 602, impacts the transition between the expanded and unexpanded sections of the casing 470. A fluidic material 714 is then injected into the apparatus 400 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 524a, 522a, 526a, 529a, 530a, 534a, 536a, 544a, 554a, 566a, 588a, 622c, 610a, and 626a thereby pressurizing the interior portion of the casing 470 below the packer cups, 572 and 582. In particular, the packer cups, 572 and 582, engage the interior surface of the casings 468 and/or 470 and thereby provide a dynamic movable fluidic seal. As a result, the pressure differential across the packer cups, 572 and 582, causes an upward tensile force that pulls the segmented expansion cone provided by the axially aligned and interleaved cone segments, 600 and 602, to be pulled upwardly out of the casings 468 and/or 407 by the packer cups thereby radially expanding and plastically deforming the casings. Furthermore, the lack of a fluid tight seal between the cone segments, 572 and 582, and the casings 468 and/or 470 permits the fluidic material 714 to lubricate the interface between the cone segments and the casings during the radial expansion and plastic deformations of the casings by the cone segments. In an exemplary embodiment, during the radial expansion and plastic deformation of the wellbore casings 468 and/or 470, the support member 402 is lifted upwardly out of the wellbore 700. In several alternative embodiments, the casings 468 and/or 470 are radially expanded and plastically deformed into engagement with at least a portion of the interior surface of the wellbore 700

Referring to Figs. 34a-34l, in an exemplary embodiment, a preexisting wellbore casing 716 is coupled to, or otherwise support by or within, the wellbore 700. In an exemplary embodiment, during the radial expansion and plastic deformation of the portion of the casing 468 and/or 470 that overlaps with the preexisting casing 716, during the continued injection of the fluidic material 714, the bypass valve body 412 is shifted downwardly relative to the gripper upper mandrel 406 thereby fluidicly coupling the casing gripper hydraulic ports, 406f and 406h. As a result, the interior passages, 428a and 440a, of the gripper bodies, 428 and 440, are pressurized thereby displacing the hydraulic slip pistons, 432a-432j and 442a-442j, radially outward into engagement with

the interior surface of the preexisting wellbore casing 716. After the hydraulic slip pistons, 432a-432j and 442a-442j, engage the preexisting wellbore casing 716, the continued injection of the fluidic material 714 causes the segmented expansion cone including the axially aligned and interleaved cone segments, 600 and 602, to be pulled through the overlapping portions of the casings 468 and/or 470 and the preexisting wellbore casing by the upward displacement of the pistons, 526, 530, and 536, relative to the preexisting wellbore casing. In this manner, the overlapping portions of the casings 468 and/or 470 and the preexisting wellbore casing 716 are simultaneously radially expanded and plastically deformed by the upward displacement of the segmented expansion cone including the axially aligned and interleaved cone segments, 600 and 602. In several alternative embodiments, the hydraulic slip pistons, 432a-432j and 442a-442j, are displaced radially outward into engagement with the interior surface of the casings 468 and/or 470 and/or the preexisting wellbore casing 716.

In an exemplary embodiment, the bypass valve body 412 is shifted downwardly relative to the gripper upper mandrel 406 by lowering the casing gripper locking dogs, 424a and 424b using the support member 402 to a position below the unexpanded portions of the casings 468 and/or 470 into the radially expanded and plastically deformed portions of the casings. The ends of the casing gripper locking dogs, 424a and 424b, may then pivot outwardly out of engagement with the outer annular recess 406d of the gripper upper mandrel 406 and then are displaced downwardly relative to the gripper upper mandrel, along with the bypass valve body 412, due to the downward longitudinal force provided by the compressed spring 418. As a result, the bypass valve body 412 is placed in the neutral position illustrated in Fig 25h. The casing gripper locking dogs, 424a and 424b, are then displaced upwardly relative to the casing gripper upper mandrel 406 using the support member 402 thereby impacting the casing gripper locking dogs with the interior diameter of the unexpanded portion of the casings 468 and/or 470. As a result, the casing gripper locking dogs, 424a and 424b, are displaced downwardly, along with the bypass valve body 412. relative to the casing gripper upper mandrel 406 until the ends of the casing gripper locking dogs pivot radially inwardly into engagement with the outer annular recess 406e of the casing gripper upper mandrel thereby positioning the bypass valve body in an active position,

as illustrated in Fig. 34a, in which the casing gripper hydraulic ports, 406f and 406h, are fluidicly coupled.

In an alternative embodiment, the bypass valve body 412 is shifted downwardly relative to the gripper upper mandrel 406 by raising the casing gripper locking dogs, 424a and 424b, to a position above the casing 468 using the support member 402 thereby permitting the ends of the casing gripper locking dogs to pivot radially outward out of engagement with the outer annular recess 406d of the gripper upper mandrel 406. The ends of the casing gripper locking dogs, 424a and 424b, are then displaced downwardly relative to the gripper upper mandrel, along with the bypass valve body 412, due to the downward longitudinal force provided by the compressed spring 418, into engagement with the outer annular recess 406e of the casing gripper upper mandrel thereby positioning the bypass valve body in an active position, as illustrated in Fig. 34a, in which the casing gripper hydraulic ports, 406f and 406h, are fluidicly coupled.

In an exemplary embodiment, the process of pulling the segmented expansion cone provided by pulling the interleaved and axially aligned cone segments 600 and 602, upwardly through the overlapping portions of the casings 468 and/or 470 and the preexisting wellbore casing 716 is repeated by repeatedly stroking the pistons, 526, 530, and 536, upwardly by repeatedly a) injecting the fluidic material 714 to pressurize the apparatus 400 thereby displacing the segmented expansion cone upwardly, b) depressurizing the apparatus by halting the injection of the fluidic material, and then c) lifting the elements of the apparatus upwardly using the support member 402 in order to properly position the pistons for another upward stroke.

Referring to Figs. 35a-35l, in an exemplary embodiment, during the operation of the apparatus 400, the segmented expansion cone provided by the interleaved and axially aligned cone segments, 600 and 602, may be collapsed thereby moving the cone segments out of axial alignment by injecting a ball plug 718 into the apparatus using the injected fluidic material 714 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, and 588a into sealing engagement with the end of the emergency releasing sleeve 622. The continued injection of the fluidic material 714 following the sealing engagement of the ball plug

718 with the end of the emergency releasing sleeve 622 will apply a downward longitudinal tensile force to the lower mandrel 610. As a result, as illustrated and described above with reference to Fig. 30a, when the downward tensile longitudinal force is initially applied to the lower mandrel 610 relative to cone mandrel 588, the lower mandrel, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 when the applied tensile force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d. As illustrated in Fig 30b, if the applied downward tensile longitudinal force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d, the lower mandrel 610, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 thereby displacing the annular recess 614a of the locking dog retainer sleeve downwardly relative to the locking dogs 616. As a result, the locking dogs 616 are released from engagement with the locking dog grooves 588h of the cone mandrel 588 thereby permitting the lower cone segments 602, the lower cam 604, and the lower cone retainer 606 to be displaced downwardly relative to the cone mandrel 588.

As illustrated in Fig. 30c, further downward displacement of the lower mandrel 610 then causes the torsion locking pin 612 to engage and displace the release housing 608 downwardly relative to the cone mandrel 588 thereby displacing the locking dogs 616, the lower cone retainer 606, the lower cam 604, and the lower cam segments 602 downwardly relative to the cone mandrel. As a result, the lower cone segments 602 and the lower cam 604 are displaced downwardly out of axial alignment with the upper cam 598 and the upper cam segments 600 thereby collapsing the segmented expansion cone. Furthermore, the downward displacement of the locking dog retainer sleeve 614 also displaced the locking ring retainer 618 and the locking ring 620 downwardly relative to the cone mandrel 588 thereby relocating the locking ring from the lock ring groove 588d to the lock ring groove 588e In this manner, the now position of the lower cone segments 602 and the lower cam 604 are thereby releasably fixed relative to the cam mandrel 588 by the locking ring 620.

Referring now to Fig 36a, an exemplary embodiment of the operation of the pressure balance piston 624 during an exemplary embodiment of the operation of the apparatus 400 will now be described. In particular, after the dart 704 is positioned and seated in

the passage 646a of the lower mandrel 646, the operating pressure within the passage 622c will increase. As a result, the operating pressure within the passages 622a will increase thereby increasing the operating pressures within the passages, 588f and 588g, of the cone mandrel 588, and within an annulus 720 defined between the cone mandrel 588 and lower mandrel 610. The operating pressure within the annulus 720 acts upon an end face of the pressure balance piston 624 thereby applying a downward longitudinal force to the cone mandrel 588. As a result, the cone mandrel 588 and the locking dog retainer sleeve 614 could inadvertently be displaced away from each other in opposite directions during the pressurization of the interior passages of the apparatus 400 caused by the placement of the dart 704 in the passage 646a of the lower mandrel 646 thereby potentially collapsing the segmented expansion cone including the interleaved and axially aligned cone segments, 600 and 602. Thus, the pressure balance piston 624, in an exemplary embodiment, neutralizes the potential effects of the pressurization of the interior passages of the apparatus 400 caused by the placement of the dart 704 in the passage 646a of the lower mandrel 646.

Referring now to Fig. 36b, an exemplary embodiment of the operation of the pressure balance piston 624 during another exemplary embodiment of the operation of the apparatus 400 will now be described. In particular, during the placement of the ball 718 within the passage 622c of the releasing sleeve 622, the interior passages of the apparatus 400 upstream from the ball are pressurized. However, since the ball 718 blocks the passage 622c, the passage 622a is not pressurized. As a result, the pressure balance piston 624 does not apply a downward longitudinal force to the cone mandrel 588. As a result, the pressure balance piston 624 does not interfere with the collapse of the segmented expansion cone including the interleaved and axially aligned cone segments, 600 and 602, caused by the placement of the ball 718 within the mouth of the passage 622c of the release sleeve 622.

An apparatus for radially expanding and plastically deforming an expandable tubular member has been described that includes a float shoe adapted to mate with an end of the expandable tubular member, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable expansion mandrel adapted to

controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, and a support member coupled to the locking device.

A method for radially expanding and plastically deforming an expandable tubular member within a borehole has been described that includes positioning an adjustable expansion mandrel within the expandable tubular member, supporting the expandable tubular member and the adjustable expansion mandrel within the borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member.

A method for forming a mono diameter wellbore casing has been described that includes positioning an adjustable expansion mandrel within a first expandable tubular member, supporting the first expandable tt nular member and the adjustable expansion mandrel within a borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the borehole, positioning the adjustable expansion mandrel within a second expandable tubular member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the borehole.

An apparatus for radially expanding and plastically deforming an expandable tubular member has been described that includes a float shoe adapted to mate with an end of

the expandable tubular member, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, a support member coupled to the locking device, and a sealing member for sealingly engaging the expandable tubular member adapted to define a pressure chamber above the adjustable expansion mandrel during radial expansion of the expandable tubular member.

A method for radially expanding and plastically deforming an expandable tubular member within a borehole has been described that includes positioning an adjustable expansion mandrel within the expandable tubular member, supporting the expandable tubular member and the adjustable expansion mandrel within the borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member within the borehole, and pressurizing an interior region of the expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the expandable tubular member within the borehole.

A method for forming a mono diameter wellbore casing has been described that includes positioning an adjustable expansion mandrel within a first expandable tubular member, supporting the first expandable tubular member and the adjustable expansion mandrel within a borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the borehole, pressurizing an interior region of the first expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the first expandable tubular member within the borehole, positioning the adjustable expansion mandrel

within a second expandable tubular member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the borehole, and pressurizing an interior region of the second expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the second expandable tubular member within the borehole.

An apparatus for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole has been described that includes a float shoe adapted to mate with an end of the expandable tubular member, a drilling member coupled to the float shoe adapted to drill the borehole, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, and a support member coupled to the locking device

A method for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole has been described that includes positioning an adjustable expansion mandrel within the expandable tubular member, coupling a drilling member to an end of the expandable tubular member, drilling the borehole using the drilling member, positioning the adjustable expansion mandrel and the expandable tubular member within the drilled borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative

to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member within the drilled borehole.

A method for forming a mono diameter wellbore casing within a borehole has been described that includes positioning an adjustable expansion mandrel within a first expandable tubular member, coupling a drilling member to an end of the first expandable tubular member, drilling a first section of the borehole using the drilling member, supporting the first expandable tubular member and the adjustable expansion mandrel within the drilled first section of the borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the drilled first section of the borehole, positioning the adjustable expansion mandrel within a second expandable tubular member, coupling the drilling member to an end of the second expandable tubular member, drilling a second section of the borehole using the drilling member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member within the second drilled section of the borehole, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the drilled second section of the borehole.

An apparatus for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole has been described that includes a float shoe adapted to mate with an end of the expandable tubular member, a drilling member coupled to the float shoe adapted to drill the borehole, an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension, an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member, a locking

device coupled to the actuator adapted to controllably engage the expandable tubular member, a support member coupled to the locking device, and a sealing member for sealing engaging the expandable tubular member adapted to define a pressure chamber above the adjustable expansion mandrel during the radial expansion of the expandable tubular member.

A method for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole has been described that includes positioning an adjustable expansion mandrel within the expandable tubular member, coupling a drilling member to an end of the expandable tubular member, drilling the borehole using the drilling member, positioning the adjustable expansion mandrel and the expandable tubular member within the drilled borehole, lowering the adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable.tubular member within the drilled borehole, and pressuring an interior portion of the expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the expandable tubular member within the drilled borehole.

A method for forming a mono diameter wellbore casing within a borehole has been described that includes positioning an adjustable expansion mandrel within a first expandable tubular member, coupling a drilling member to an end of the first expandable tubular member, drilling a first section of the borehole using the drilling member, supporting the first expandable tubular member and the adjustable expansion mandrel within the drilled first section of the borehole, lowering the adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the drilled first section of the borehole, pressuring an interior portion of the first expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the first expandable tubular member within the

first drilled section of the borehole, positioning the adjustable expansion mandrel within a second expandable tubular member, coupling the drilling member to an end of the second expandable tubular member, drilling a second section of the borehole using the drilling member, supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member within the second drilled section of the borehole, lowering the adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the drilled second section of the borehole, and pressuring an interior portion of the second expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the second expandable tubular member within the drilled second section of the borehole.

An apparatus for radially expanding and plastically deforming an expandable tubular member has been described that includes a float shoe adapted to mate with an end of the expandable tubular member, a first adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a first larger outside dimension for radial expansion of the expandable tubular member or collapsed to a first smaller outside dimension, a second adjustable expansion mandrel coupled to the first adjustable expansion mandrel adapted to be controllably expanded to a second larger outside dimension for radial expansion of the expandable tubular member or collapsed to a second smaller outside dimension, an actuator coupled to the first and second adjustable expansion mandrels adapted to controllably displace the first and second adjustable expansion mandrels relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, and a support member coupled to the locking device. The first larger outside dimension of the first adjustable expansion mandrel is larger than the second larger outside dimension of the second adjustable expansion mandrel.

A method for radially expanding and plastically deforming an expandable tubular member within a borehole has been described that includes positioning first and

second adjustable expansion mandrels within the expandable tubular member, supporting the expandable tubular member and the first and second adjustable expansion mandrels within the borehole, lowering the first adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform a lower portion of the expandable tubular member, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, and displacing the second adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform portions of the expandable tubular member above the lower portion of the expandable tubular member. The outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

A method for forming a mono diameter wellbore casing has been described that includes positioning first and second adjustable expansion mandrels within a first expandable tubular member, supporting the first expandable tubular member and the first and second adjustable expansion mandrels within a borehole, lowering the first adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform a lower portion of the first expandable tubular member, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the first expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform portions of the first expandable tubular member above the lower portion of the expandable tubular member, positioning first and second adjustable expansion mandrels within a second expandable tubular member, supporting the first expandable tubular member and the

first and second adjustable expansion mandrels within the borehole in overlapping relation to the first expandable tubular member, lowering the first adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform a lower portion of the second expandable tubular member, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the second expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, and displacing the second adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform portions of the second expandable tubular member above the lower portion of the second expandable tubular member. The outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

An apparatus for radially expanding and plastically deforming an expandable tubular member has been described that includes a floa shoe adapted to mate with an end of the expandable tubular member, a first adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a first larger outside dimension for radial expansion of the expandable tubular member or collapsed to a first smaller outside dimension, a second adjustable expansion mandrel coupled to the first adjustable expansion mandrel adapted to be controllably expanded to a second larger outside dimension for radial expansion of the expandable tubular member or collapsed to a second smaller outside dimension, an actuator coupled to the first and second adjustable expansion mandrels adapted to controllably displace the first and second adjustable expansion mandrels relative to the expandable tubular member, a locking device coupled to the actuator adapted to controllably engage the expandable tubular member, a support member coupled to the locking device, and a sealing member for sealingly engaging the expandable tubular adapted to define a pressure chamber above the first and second adjustable expansion mandrels during the radial expansion of the expandable tubular member. The first larger outside dimension of the first adjustable expansion mandrel is larger than the second larger outside dimension of the second adjustable expansion mandrel.

A method for radially expanding and plastically deforming an expandable tubular member within a borehole has been described that includes positioning first and second adjustable expansion mandrels within the expandable tubular member, supporting the expandable tubular member and the first and second adjustable expansion mandrels within the borehole, lowering the first adjustable expansion mandrel out of the expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform a lower portion of the expandable tubular member, pressurizing an interior region of the expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the expandable tubular member by the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform portions of the expandable tubular member above the lower portion of the expandable tubular member, and pressurizing an interior region of the expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the expandable tubular member above the lower portion of the expandable tubular member by the second adjustable expansion mandrel. The outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

A method for forming a mono diameter wellbore casing has been described that includes positioning first and second adjustable expansion mandrels within a first expandable tubular member, supporting the first expandable tubular member and the first and second adjustable expansion mandrels within a borehole, lowering the first adjustable expansion mandrel out of the first expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform a lower portion of the first expandable tubular

member, pressurizing an interior region of the first expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the first expandable tubular member by the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the first expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform portions of the first expandable tubular member above the lower portion of the expandable tubular member, pressurizing an interior region of the first expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the first expandable tubular member above the lower portion of the first expandable tubular member by the second adjustable expansion mandrel, positioning first and second adjustable expansion mandrels within a second expandable tubular member, supporting the first expandable tubular member and the first and second adjustable expansion mandrels within the borehole in overlapping relation to the first expandable tubular member, lowering the first adjustable expansion mandrel out of the second expandable tubular member, increasing the outside dimension of the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform a lower portion of the second expandable tubular member, pressurizing an interior region of the second expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the second expandable tubular member by the first adjustable expansion mandrel, displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the second expandable tubular member, decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel, displacing the second adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform portions of the second expandable tubular member above the lower portion of the second expandable tubular member, and pressurizing an interior region of the second expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the second expandable tubular member

above the lower portion of the second expandable tubular member by the second adjustable expansion mandrel. The outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

An apparatus for radially expanding and plastically deforming an expandable tubular member has been described that includes a support member, a locking device coupled to the support member and releasably coupled to the expandable tubular member, an adjustable expansion mandrel adapted to be controllably expanded to a larger outside dimension for radial expansion and plastic deformation of the expandable tubular member or collapsed to a smaller outside dimension, and an actuator coupled to the locking member and the adjustable expansion mandrel adapted to displace the adjustable expansion mandrel upwardly through the expandable tubular member to radially expand and plastically deform a portion of the expandable tubular member. In an exemplary embodiment, the apparatus further includes a gripping assembly coupled to the support member and the actuator for controllably gripping at least one of the expandable tubular member or another tubular member. In an exemplary embodiment, the apparatus further includes one or more cup seals coupled to the support member for sealingly engaging the expandable tubular member above the adjustable expansion mandrel. In an exemplary embodiment, the apparatus further includes an expansion mandrel coupled to the adjustable expansion mandrel, and a float collar assembly coupled to the adjustable expansion mandrel that includes a float valve assembly and a sealing sleeve coupled to the float valve assembly adapted to be radially expanded and plastically deformed by the expansion mandrel.

A method for radially expanding and plastically deforming an expandable tubular member within a borehole has also been described that includes supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion mandrel within the borehole, increasing the size of the adjustable expansion mandrel, and displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member. In an exemplary embodiment, the method further includes reducing the size of the adjustable expansion mandrel after the portion of the expandable tubular member has been radially expanded and plastically

deformed. In an exemplary embodiment, the method further includes fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member after reducing the size of the adjustable expansion mandrel. In an exemplary embodiment, the method further includes permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator after fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member. In an exemplary embodiment, the method further includes injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and a preexisting structure after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator. In an exemplary embodiment, the method further includes increasing the size of the adjustable expansion mandrel after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator. In an exemplary embodiment, the method further includes displacing the adjustable expansion cone upwardly relative to the expandable tubular member to radially expand and plastically deform another portion of the expandable tubular member. In an exemplary embodiment, the method further includes if the end of the other portion of the expandable tubular member overlaps with a preexisting structure, then not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator, and displacing the adjustable expansion cone upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform the end of the other portion of the expandable tubular member that overlaps with the preexisting structure.

A method for forming a mono diameter wellbore casing within a borehole that includes a preexisting wellbore casing has been described that includes supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion mandrel within the borehole, increasing the size of the adjustable expansion mandrel, displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member, and displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member and a portion of the preexisting wellbore casing that overlaps with an end of the remaining

portion of the expandable tubular member. In an exemplary embodiment, the method further includes reducing the size of the adjustable expansion mandrel after the portion of the expandable tubular member has been radially expanded and plastically deformed. In an exemplary embodiment, the method further includes fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member after reducing the size of the adjustable expansion mandrel. In an exemplary embodiment, the method further includes permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator after fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member In an exemplary embodiment, the method further includes injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the borehole after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator. In an exemplary embodiment, the method further includes increasing the size of the adjustable expansion mandrel after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator. In an exemplary embodiment, the method further includes displacing the adjustable expansion cone upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member. In an exemplary embodiment, the method further includes not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator, and displacing the adjustable expansion cone upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform the end of the remaining portion of the expandable tubular member that overlaps with the preexisting wellbore casing after not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

It is understood that variations may be made in the foregoing without departing from the scope of the invention. For example, the teachings of the present illustrative embodiments may be used to provide a wellbore casing, a pipeline, or a structural support Furthermore, the elements and teachings of the various illustrative embodiments may be combined in whole or in part in some or all of the illustrative embodiments. In addition, the expansion surfaces of the upper and lower cone segments, 600 and 602, may include any form of inclined surface or combination of

inclined surfaces such as, for example, conical, spherical, elliptical, and/or parabolic that may or may not be faceted. Finally, one or more of the steps of the methods of operation of the exemplary embodiments may be omitted and/or performed in another order.

Although illustrative embodiments of the invention have been shown and described, a wide range of modification, changes and substitution is contemplated in the foregoing disclosure. In some instances, some features of the present invention may be employed without a corresponding use of the other features. Accordingly, it is appropriate that the appended claims be construed broadly and in a manner consistent with the scope of the invention.

Claims

What is claimed is:

1. A method for forming a mono diameter wellbore casing within a borehole that includes a preexisting wellbore casing, comprising:

supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion device within the borehole;

increasing the size of the adjustable expansion device;

displacing the adjustable expansion device upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member; and

displacing the adjustable expansion device upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member and a portion of the preexisting wellbore casing that overlaps with an end of the remaining portion of the expandable tubular member.

2. The method of claim 1, further comprising:

reducing the size of the adjustable expansion device after the portion of the expandable tubular member has been radially expanded and plastically deformed.

3. The method of claim 2, further comprising:

fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member after reducing the size of the adjustable expansion device.

4. The method of claim 3, further comprising:

permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator after fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member.

5. The method of claim 4, further comprising:

injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the borehole after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

6. The method of claim 4, further comprising:

increasing the size of the adjustable expansion device after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

7. The method of claim 6, further comprising:

displacing the adjustable expansion cone upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member.

8. The method of claim 7, further comprising:

not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator; and

displacing the adjustable expansion cone upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform the end of the remaining portion of the expandable tubular member that overlaps with the pre-existing wellbore casing after not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

1. An apparatus for radially expanding and plastically deforming an expandable tubular member, comprising:

a float shoe adapted to mate with an end of the expandable tubular member;

an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension;

an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member,

a locking device coupled to the actuator adapted to controllably engage the expandable tubular member; and

a support member coupled to the locking device.

2. A method for radially expanding and plastically deforming an expandable tubular member within a borehole, comprising:

positioning an adjustable expansion mandrel within the expandable tubular member;

supporting the expandable tubular member and the adjustable expansion mandrel within the borehole,

lowering the adjustable expansion mandrel out of the expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel; and

displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member.

3. A method for forming a mono diameter wellbore casing, comprising:

positioning an adjustable expansion mandrel within a first expandable tubular member;

supporting the first expandable tubular member and the adjustable expansion mandrel within a borehole;

lowering the adjustable expansion mandrel out of the first expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the borehole;

positioning the adjustable expansion mandrel within a second expandable tubular member;

supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member;

lowering the adjustable expansion mandrel out of the second expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel; and

displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the borehole.

4. An apparatus for radially expanding and plastically deforming an expandable tubular member, comprising:

a float shoe adapted to mate with an end of the expandable tubular member;

an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension;

an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member;

a locking device coupled to the actuator adapted to controllably engage the expandable tubular member;

a support member coupled to the locking device; and

a sealing member for sealingly engaging the expandable tubular member adapted to define a pressure chamber above the adjustable expansion mandrel during radial expansion of the expandable tubular member.

5. A method for radially expanding and plastically deforming an expandable tubular member within a borehole, comprising:

positioning an adjustable expansion mandrel within the expandable tubular member;

supporting the expandable tubular member and the adjustable expansion mandrel within the borehole;

lowering the adjustable expansion mandrel out of the expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member within the borehole; and

pressurizing an interior region of the expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the expandable tubular member within the borehole.

6. A method for forming a mono diameter wellbore casing, comprising:

positioning an adjustable expansion mandrel within a first expandable tubular member;

supporting the first expandable tubular member and the adjustable expansion mandrel within a borehole;

lowering the adjustable expansion mandrel out of the first expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the borehole;

pressurizing an interior region of the first expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the first expandable tubular member within the borehole;

positioning the adjustable expansion mandrel within a second expandable tubular member;

supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member;

lowering the adjustable expansion mandrel out of the second expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the borehole; and

pressurizing an interior region of the second expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the second expandable tubular member within the borehole.

7 An apparatus for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole, comprising:

a float shoe adapted to mate with an end of the expandable tubular member;

a drilling member coupled to the float shoe adapted to drill the borehole;

an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension;

an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member;

a locking device coupled to th• actuator adapted to controllably engage the expandable tubular member; and

a support member coupled to the locking device.

8. A method for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole, comprising:

positioning an adjustable expansion mandrel within the expandable tubular member;

coupling a drilling member to an end of the expandable tubular member;

drilling the borehole using the drilling member;

positioning the adjustable expansion mandrel and the expandable tubular member within the drilled borehole;

lowering the adjustable expansion mandrel out of the expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel; and

displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member within the drilled borehole.

9. A method for forming a mono diameter wellbore casing within a borehole, comprising:

positioning an adjustable expansion mandrel within a first expandable tubular member;

coupling a drilling member to an end of the first expandable tubular member;

drilling a first section of the borehole using the drilling member;

supporting the first expandable tubular member and the adjustable expansion mandrel within the drilled first section of the borehole;

lowering the adjustable expansion mandrel out of the first expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the drilled first section of the borehole;

positioning the adjustable expansion mandrel within a second expandable tubular member,

coupling the drilling member to an end of the second expandable tubular member;

drilling a second section of the borehole using the drilling member;

supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member within the second drilled section of the borehole;

lowering the adjustable expansion mandrel out of the second expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel; and

displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the drilled second section of the borehole.

10 An apparatus for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole, comprising:

a float shoe adapted to mate with an end of the expandable tubular member;

a drilling member coupled to the float shoe adapted to drill the borehole;

an adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a larger outside dimension for radial expansion of the expandable tubular member or collapsed to a smaller outside dimension;

an actuator coupled to the adjustable expansion mandrel adapted to controllably displace the adjustable expansion mandrel relative to the expandable tubular member,

a locking device coupled to the actuator adapted to controllably engage the expandable tubular member;

a support member coupled to the locking device; and

a sealing member for sealing engaging the expandable tubular member adapted to define a pressure chamber above the adjustable expansion mandrel during the radial expansion of the expandable tubular member.

11. A method for drilling a borehole within a subterranean formation and then radially expanding and plastically deforming an expandable tubular member within the drilled borehole, comprising:

positioning an adjustable expansion mandrel within the expandable tubular member;

coupling a drilling member to an end of the expandable tubular member;

drilling the borehole using the drilling member;

positioning the adjustable expansion mandrel and the expandable tubular member within the drilled borehole;

lowering the adjustable expansion mandrel out of the expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member n times to radially expand and plastically deform n portions of the expandable tubular member within the drilled borehole; and

pressuring an interior portion of the expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the expandable tubular member within the drilled borehole.

12. A method for forming a mono diameter wellbore casing within a borehole, comprising:

positioning an adjustable expansion mandrel within a first expandable tubular member;

coupling a drilling member to an end of the first expandable tubular member;

drilling a first section of the borehole using the drilling member;

supporting the first expandable tubular member and the adjustable expansion mandrel within the drilled first section of the borehole;

lowering the adjustable expansion mandrel out of the first expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the first expandable tubular member m times to radially expand and plastically deform m portions of the first expandable tubular member within the drilled first section of the borehole;

pressuring an interior portion of the first expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the first expandable tubular member within the first drilled section of the borehole;

positioning the adjustable expansion mandrel within a second expandable tubular member;

coupling the drilling member to an end of the second expandable tubular member;

drilling a second section of the borehole using the drilling member,

supporting the second expandable tubular member and the adjustable expansion mandrel within the borehole in overlapping relation to the first expandable tubular member within the second drilled section of the borehole;

lowering the adjustable expansion mandrel out of the second expandable tubular member;

increasing the outside dimension of the adjustable expansion mandrel,

displacing the adjustable expansion mandrel upwardly relative to the second expandable tubular member n times to radially expand and plastically deform n portions of the second expandable tubular member within the drilled second section of the borehole, and

pressuring an interior portion of the second expandable tubular member above the adjustable expansion mandrel during the radial expansion and plastic deformation of the second expandable tubular member within the drilled second section of the borehole.

13. An apparatus for radially expanding and plastically deforming an expandable tubular member, comprising:

a float shoe adapted to mate with an end of the expandable tubular member;

a first adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a first larger outside dimension for radial expansion of the expandable tubular member or collapsed to a first smaller outside dimension;

a second adjustable expansion mandrel coupled to the first adjustable expansion mandrel adapted to be controllably expanded to a second larger outside dimension for radial expansion of the expandable tubular member or collapsed to a second smaller outside dimension;

an actuator coupled to the first and second adjustable expansion mandrels adapted to controllably displace the first and second adjustable expansion mandrels relative to the expandable tubular member;

a locking device coupled to the actuator adapted to controllably engage the expandable tubular member; and

a support member coupled to the locking device;

wherein the first larger outside dimension of the first adjustable expansion mandrel is larger than the second larger outside dimension of the second adjustable expansion mandrel.

14. A method for radially expanding and plastically deforming an expandable tubular member within a borehole, comprising:

positioning first and second adjustable expansion mandrels within the expandable tubular member;

supporting the expandable tubular member and the first and second adjustable expansion mandrels within the borehole;

lowering the first adjustable expansion mandrel out of the expandable tubular member,

increasing the outside dimension of the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform a lower portion of the expandable tubular member;

displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the expandable tubular member;

decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel;

displacing the second adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform portions of the expandable tubular member above the lower portion of the expandable tubular member;

wherein the outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

15. A method for forming a mono diameter wellbore casing, comprising:

positioning first and second adjustable expansion mandrels within a first expandable tubular member;

supporting the first expandable tubular member and the first and second adjustable expansion mandrels within a borehole;

lowering the first adjustable expansion mandrel out of the first expandable tubular member,

increasing the outside dimension of the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform a lower portion of the first expandable tubular member;

displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the first expandable tubular member;

decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel;

displacing the second adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform portions of the first expandable tubular member above the lower portion of the expandable tubular member;

positioning first and second adjustable expansion mandrels within a second expandable tubular member;

supporting the first expandable tubular member and the first and second adjustable expansion mandrels within the borehole in overlapping relation to the first expandable tubular member;

lowering the first adjustable expansion mandrel out of the second expandable tubular member;

increasing the outside dimension of the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform a lower portion of the second expandable tubular member;

displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the second expandable tubular member;

decreasing the outside dimer•ion of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel; and

displacing the second adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform portions of the second expandable tubular member above the lower portion of the second expandable tubular member;

wherein the outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

16. An apparatus for radially expanding and plastically deforming an expandable tubular member, comprising:

a float shoe adapted to mate with an end of the expandable tubular member;

a first adjustable expansion mandrel coupled to the float shoe adapted to be controllably expanded to a first larger outside dimension for radial expansion of the expandable tubular member or collapsed to a first smaller outside dimension;

a second adjustable expansion mandrel coupled to the first adjustable expansion mandrel adapted to be controllably expanded to a second larger outside dimension for

radial expansion of the expandable tubular member or collapsed to a second smaller outside dimension;

an actuator coupled to the first and second adjustable expansion mandrels adapted to controllably displace the first and second adjustable expansion mandrels relative to the expandable tubular member;

a locking device coupled to the actuator adapted to controllably engage the expandable tubular member,

a support member coupled to the locking device; and

a sealing member for sealingly engaging the expandable tubular adapted to define a pressure chamber above the first and second adjustable expansion mandrels during the radial expansion of the expandable tubular member;

wherein the first larger outside dimension of the first adjustable expansion mandrel is larger than the second larger outside dimension of the second adjustable expansion mandrel.

17. A method for radially expanding and plastically deforming an expandable tubular member within a borehole, comprising:

positioning first and second adjustable expansion mandrels within the expandable tubular member;

supporting the expandable tubular member and the first and second adjustable expansion mandrels within the borehole;

lowering the first adjustable expansion mandrel out of the expandable tubular member;

increasing the outside dimension of the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform a lower portion of the expandable tubular member;

pressurizing an interior region of the expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the expandable tubular member by the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the expandable tubular member;

decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel;

displacing the second adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform portions of the expandable tubular member above the lower portion of the expandable tubular member; and

pressurizing an interior region of the expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the expandable tubular member above the lower portion of the expandable tubular member by the second adjustable expansion mandrel;

wherein the outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

18. A method for forming a mono diameter wellbore casing, comprising:

positioning first and second adjustable expansion mandrels within a first expandable tubular member;

supporting the first expandable tubular member and the first and second adjustable expansion mandrels within a borehole;

lowering the first adjustable expansion mandrel out of the first expandable tubular member;

increasing the outside dimension of the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform a lower portion of the first expandable tubular member;

pressurizing an interior region of the first expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the first expandable tubular member by the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the first expandable tubular member;

decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel;

displacing the second adjustable expansion mandrel upwardly relative to the first expandable tubular member to radially expand and plastically deform portions of the first expandable tubular member above the lower portion of the expandable tubular member;

pressurizing an interior region of the first expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the first expandable tubular member above the lower portion of the first expandable tubular member by the second adjustable expansion mandrel;

positioning first and second adjustable expansion mandrels within a second expandable tubular member,

supporting the first expandable tubular member and the first and second adjustable expansion mandrels within the borehole in overlapping relation to the first expandable tubular member;

lowering the first adjustable expansion mandrel out of the second expandable tubular member,

increasing the outside dimension of the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform a lower portion of the second expandable tubular member;

pressurizing an interior region of the second expandable tubular member above the first adjustable expansion mandrel during the radial expansion of the lower portion of the second expandable tubular member by the first adjustable expansion mandrel;

displacing the first adjustable expansion mandrel and the second adjustable expansion mandrel downwardly relative to the second expandable tubular member;

decreasing the outside dimension of the first adjustable expansion mandrel and increasing the outside dimension of the second adjustable expansion mandrel;

displacing the second adjustable expansion mandrel upwardly relative to the second expandable tubular member to radially expand and plastically deform portions of the second expandable tubular member above the lower portion of the second expandable tubular member, and

pressurizing an interior region of the second expandable tubular member above the second adjustable expansion mandrel during the radial expansion of the portions of the second expandable tubular member above the lower portion of the second expandable tubular member by the second adjustable expansion mandrel;

wherein the outside dimension of the first adjustable expansion mandrel is greater than the outside dimension of the second adjustable expansion mandrel.

19. An apparatus for radially expanding and plastically deforming an expandable tubular member, comprising:

a support member;

a locking device coupled to the support member and releasably coupled to the expandable tubular member;

an adjustable expansion mandrel adapted to be controllably expanded to a larger outside dimension for radial expansion and plastic deformation of the expandable tubular member or collapsed to a smaller outside dimension; and

an actuator coupled to the locking member and the adjustable expansion mandrel adapted to displace the adjustable expansion mandrel upwardly through the expandable tubular member to radially expand and plastically deform a portion of the expandable tubular member.

20 The apparatus of claim 19, further comprising:

a gripping assembly coupled to the support member and the actuator for controllably gripping at least one of the expandable tubular member or another tubular member.

21. The apparatus of claim 19, further comprising:

one or more cup seals coupled to the support member for sealingly engaging the expandable tubular member above the adjustable expansion mandrel.

22. The apparatus of claim 19, further comprising:

an expansion mandrel coupled to the adjustable expansion mandrel; and

a float collar assembly coupled to the adjustable expansion mandrel comprising:

a float valve assembly; and

a sealing sleeve coupled to the float valve assembly adapted to be radially expanded and plastically deformed by the expansion mandrel.

23. A method for radially expanding and plastically deforming an expandable tubular member within a borehole, comprising:

supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion mandrel within the borehole;

increasing the size of the adjustable expansion mandrel; and

displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member.

24. The method of claim 23, further comprising:

reducing the size of the adjustable expansion mandrel after the portion of the expandable tubular member has been radially expanded and plastically deformed.

25. The method of claim 24, further comprising:

fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member after reducing the size of the adjustable expansion mandrel.

26 The method of claim 25, further comprising:

permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator after fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member.

27. The method of claim 26, further comprising:

injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and a preexisting structure after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

28. The method of claim 26, further comprising:

increasing the size of the adjustable expansion mandrel after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

29. The method of claim 28, further comprising:

displacing the adjustable expansion cone upwardly relative to the expandable tubular member to radially expand and plastically deform another portion of the expandable tubular member.

30. The method of claim 29, further comprising:

if the end of the other portion of the expandable tubular member overlaps with a preexisting structure, then

not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator; and

displacing the adjustable expansion cone upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform the end of the other portion of the expandable tubular member that overlaps with the preexisting structure.

31. A method for forming a mono diameter wellbore casing within a borehole that includes a preexisting wellbore casing, comprising.

supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion mandrel within the borehole;

increasing the size of the adjustable expansion mandrel;

displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member; and

displacing the adjustable expansion mandrel upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member and a portion of the preexisting wellbore casing that overlaps with an end of the remaining portion of the expandable tubular member.

32. The method of claim 31, further comprising:

reducing the size of the adjustable expansion mandrel after the portion of the expandable tubular member has been radially expanded and plastically deformed.

33. The method of claim 32, further comprising:

fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member after reducing the size of the adjustable expansion mandrel

34. The method of claim 33, further comprising:

permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator after fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member.

35. The method of claim 34, further comprising:

injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the borehole after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

36. The method of claim 34, further comprising:

increasing the size of the adjustable expansion mandrel after permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

37. The method of claim 36, further comprising:

displacing the adjustable expansion cone upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member

38. The method of claim 37, further comprising:

not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator; and

displacing the adjustable expansion cone upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform the end of the remaining portion of the expandable tubular member that overlaps with the preexisting wellbore casing after not permitting the position of the expandable tubular member to float relative to the position of the hydraulic actuator.

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Application No: GB0509620.1

Claims searched: 1 & 2

Examiner: Bob Crowshaw

Date of search: 27 September 2005

Patents Act 1977: Search Report under Section 17

Documents considered to be relevant:

Category	Relevant to claims	Identity of document and passage or figure of particular relevance
Y	1 & 2	US3191677 A (KINLEY) Note the actuator for displacing the adjustable expansion device relative to an expandable tubular member. Note also the pre-existing wellbore casing.
Y	1& 2	US4420866 A (MUELLER) Note the hydraulic actuator used in expanding and plastically deforming a tubular member.

Categories:

X	Document indicating lack of novelty or inventive step	A	Document indicating technological background and/or state of the art.
Y	Document indicating lack of inventive step if combined with one or more other documents of same category.	P	Document published on or after the declared priority date but before the filing date of this invention.
&	Member of the same patent family	E	Patent document published on or after, but with priority date earlier than, the filing date of this application

Field of Search:

Search of GB, EP, WO & US patent documents classified in the following areas of the UKC^{X} :

Worldwide search of patent documents classified in the following areas of the IPC^{07}

E21B

The following online and other databases have been used in the preparation of this search report

EPODOC, JAPIO, WPI, TXTE (FULLTEXT)

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Certificate of Grant of Patent

Patent Number: GB2414749

Proprietor(s): Enventure Global Technology

Inventor(s):
Lev Ring
David P Brisco
Brock W Watson
Kevin K Waddell

This is to Certify that, in accordance with the Patents Act 1977,

a Patent has been granted to the proprietor(s) for an invention entitled "**Mono diameter wellbore casing**" disclosed in an application filed **12 November 2002.**

Dated 28 June 2006

THE PATENT OFFICE

DIEU ET MON DROIT

Ron Marchant
Comptroller General of Patents,
Designs and Trade Marks
UNITED KINGDOM PATENT OFFICE

IMPORTANT NOTES FOR PROPRIETORS OF UNITED KINGDOM PATENTS

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Blank Patent Forms 12/77 and fee sheets (FS2) can be requested by post from The Central Enquiry Unit, The Patent Office, Concept House, Cardiff Road, Newport, South Wales NP10 8QQ, by telephone on 08459-500505 (Minicom 08459-222250), by fax on 01633-813600 or by e-mail (enquiries@patent.gov.uk). The Forms and fee sheets can also be downloaded from the Patent Office website (www.patent.gov.uk).

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We shall be pleased to provide further advice on specific problems relating to any of the above topics

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(21) Application No: **0509620.1**

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Other: **EPODOC, JAPIO, WPI, TXTE (FULLTEXT)**
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Brock Wayne Watson
Kevin Karl Waddell

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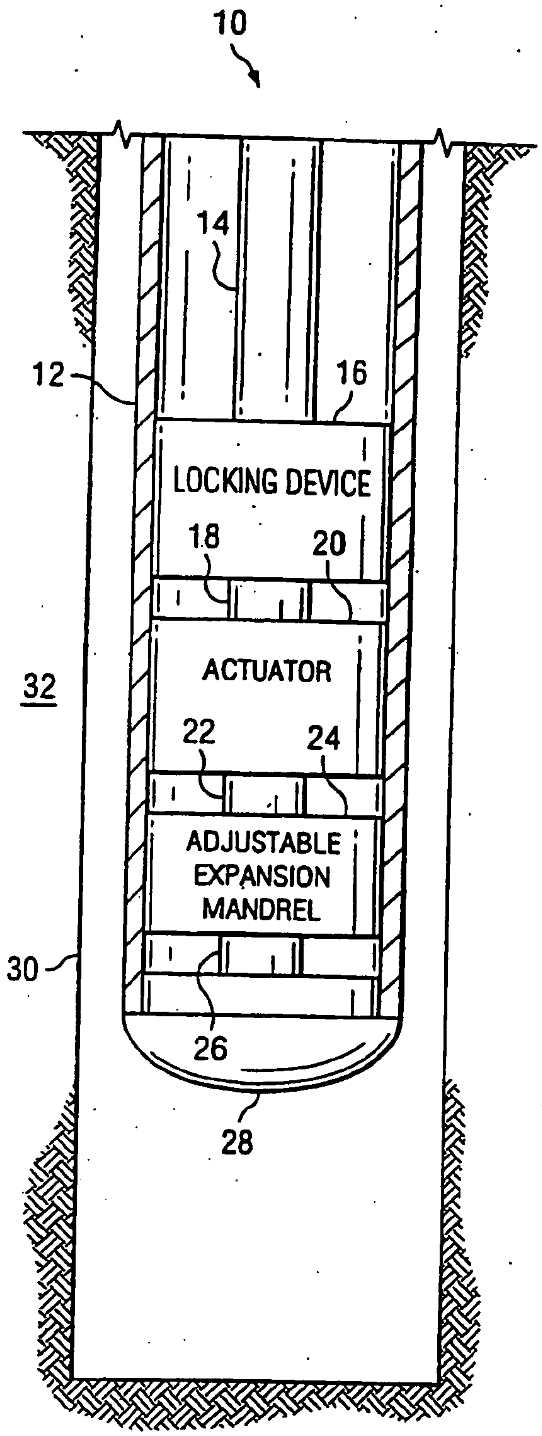
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ACTUATOR
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ADJUSTABLE EXPANSION MANDREL
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Fig. 1

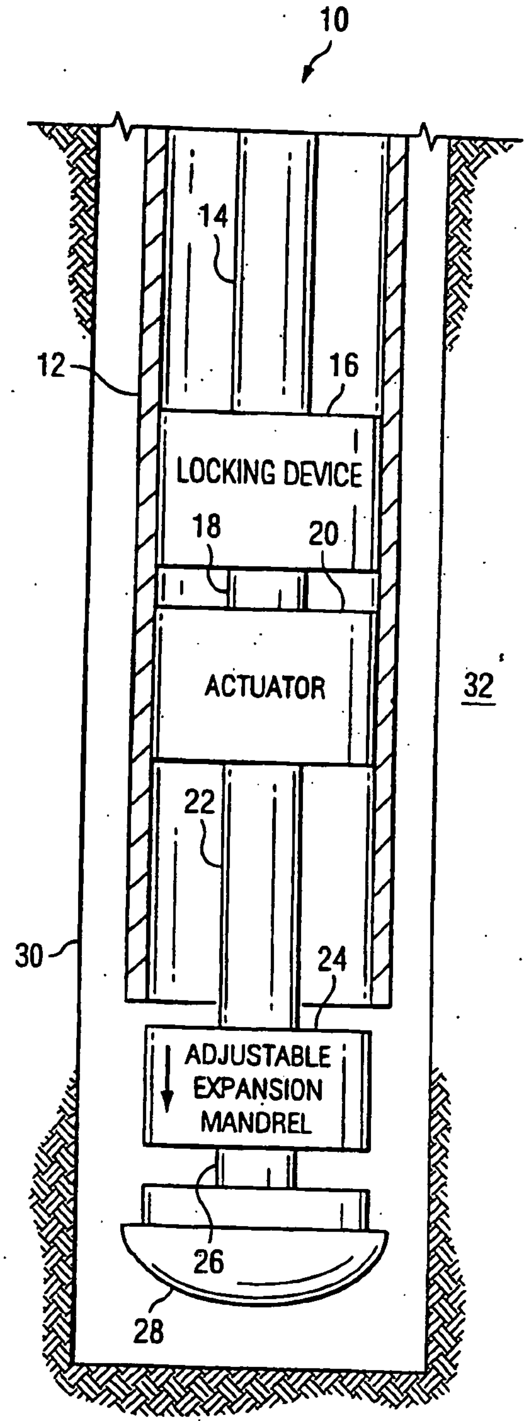
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Fig. 2

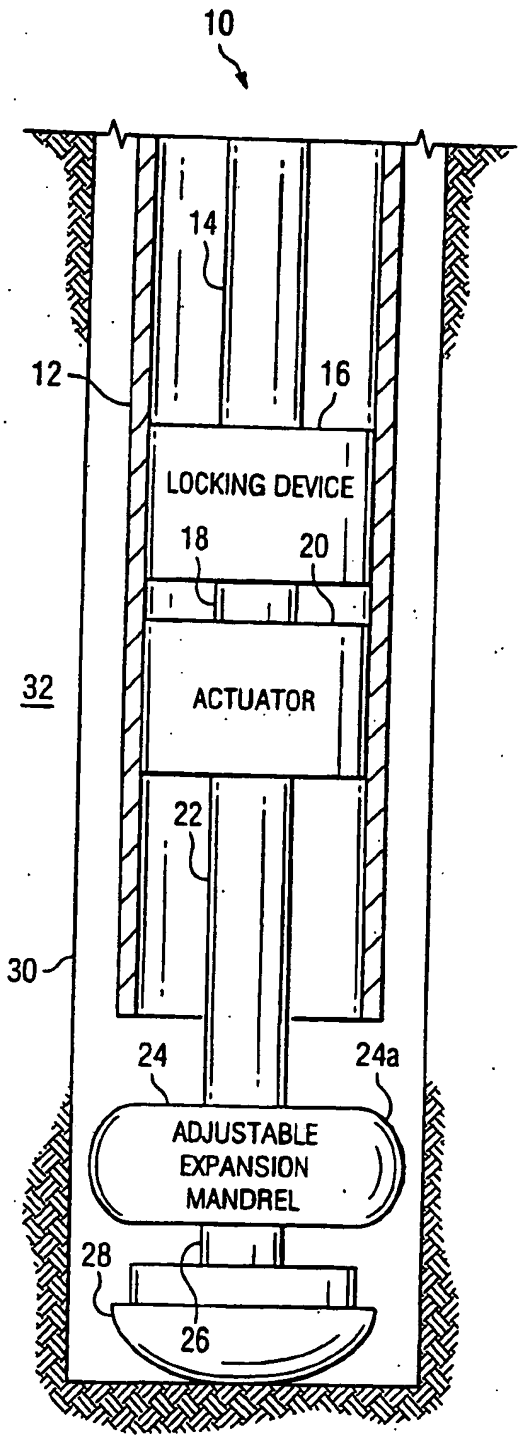
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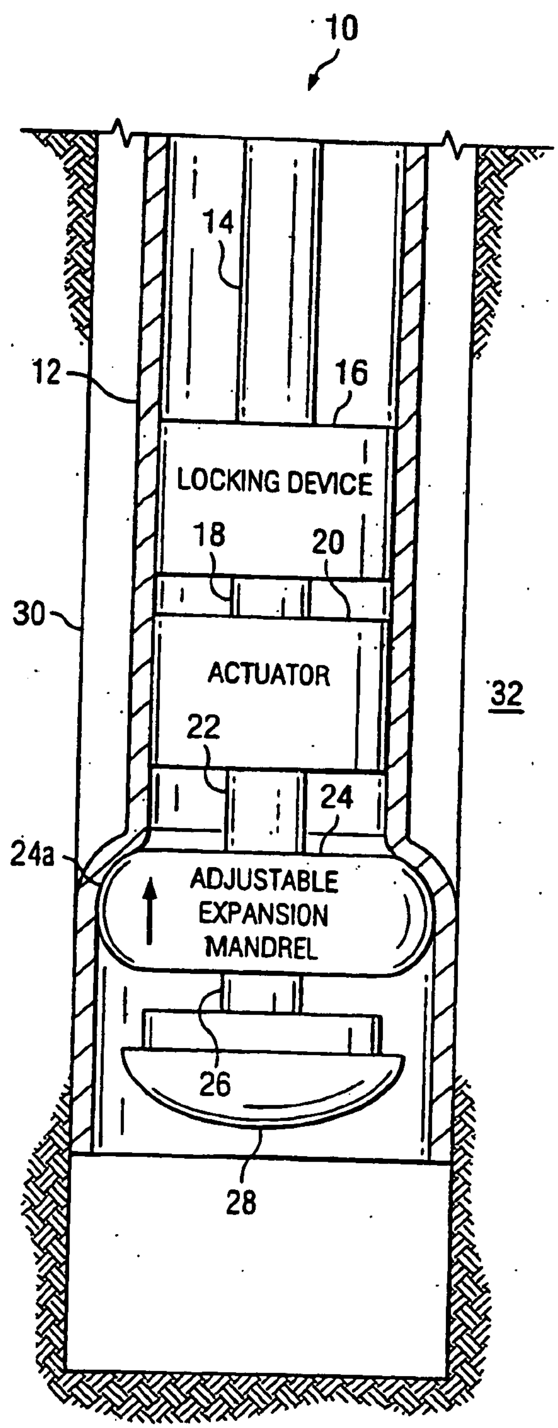
Fig. 3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EXPANSION
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Fig. 4

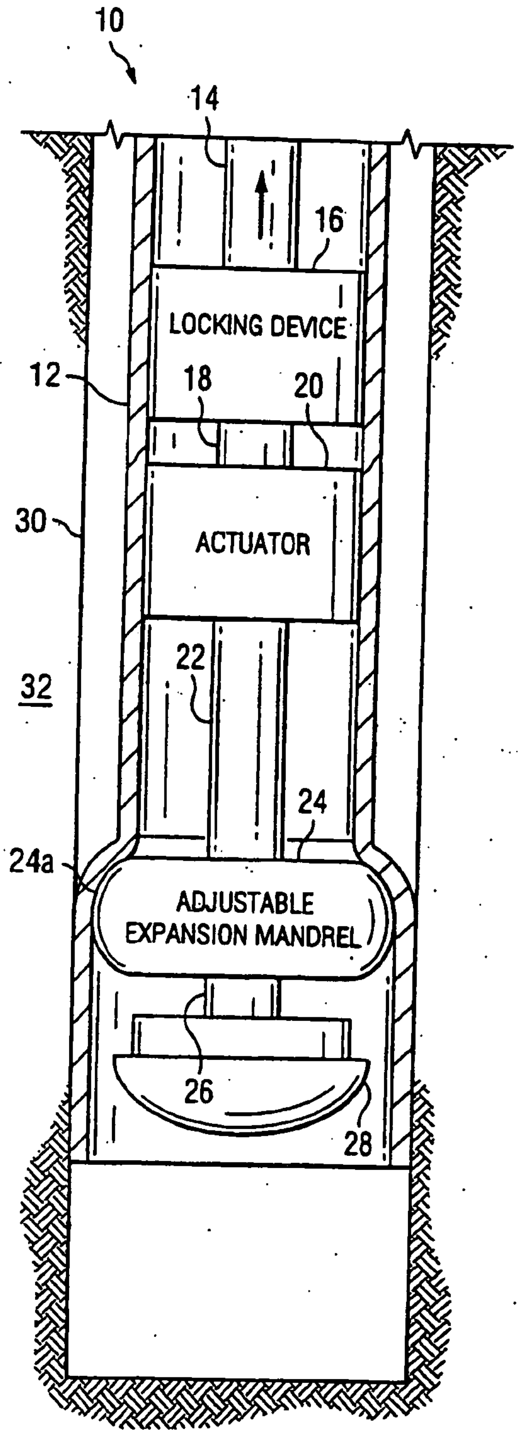
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Fig. 5

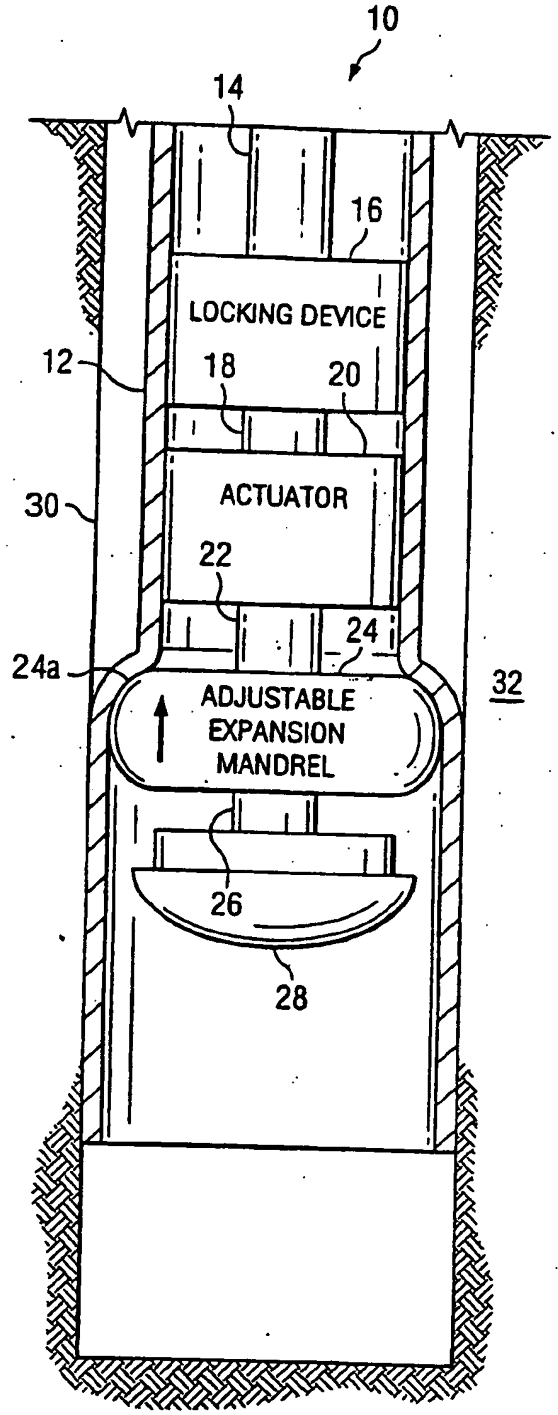
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Fig. 6

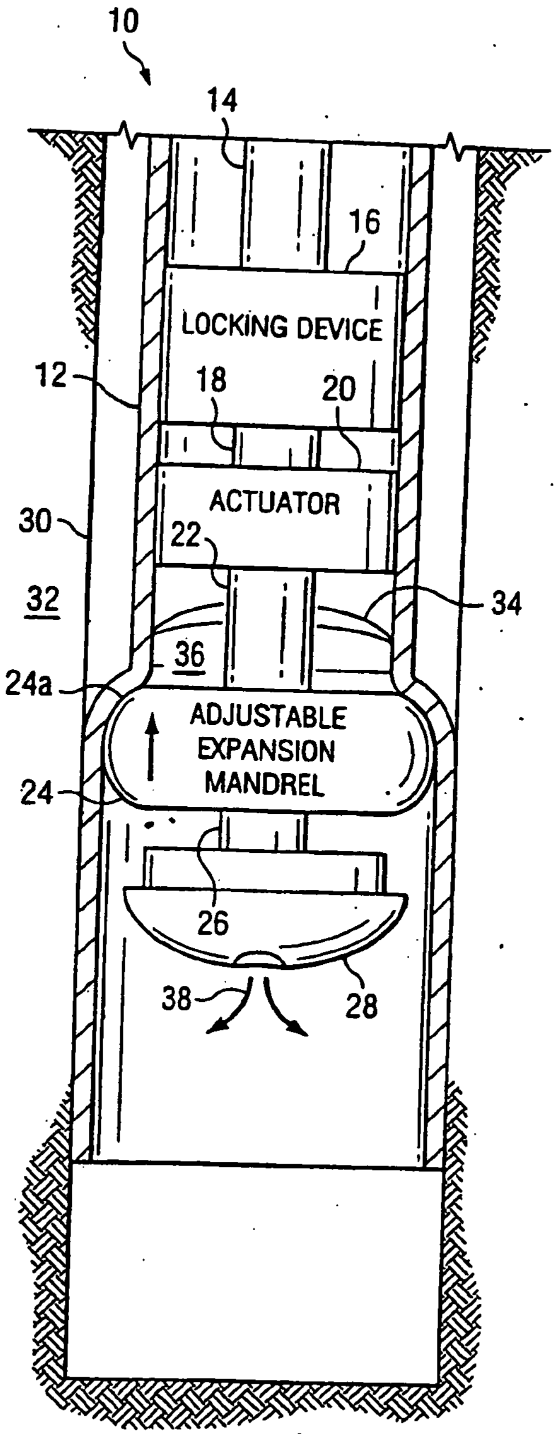
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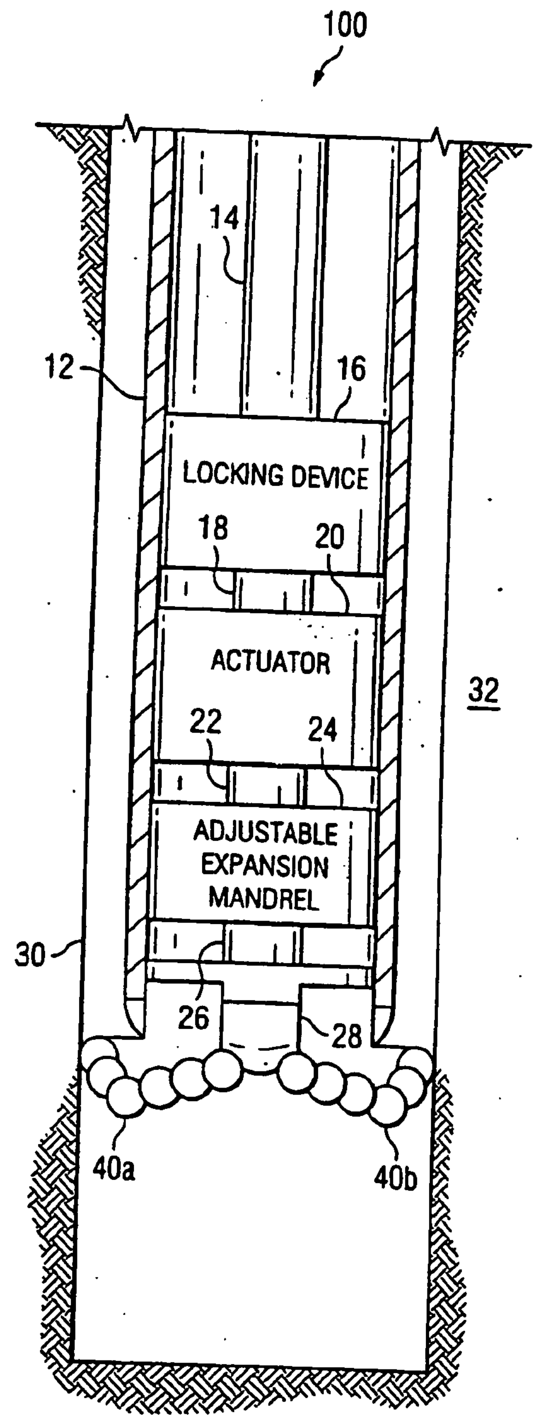
Fig. 6a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40a
40b

Fig. 7

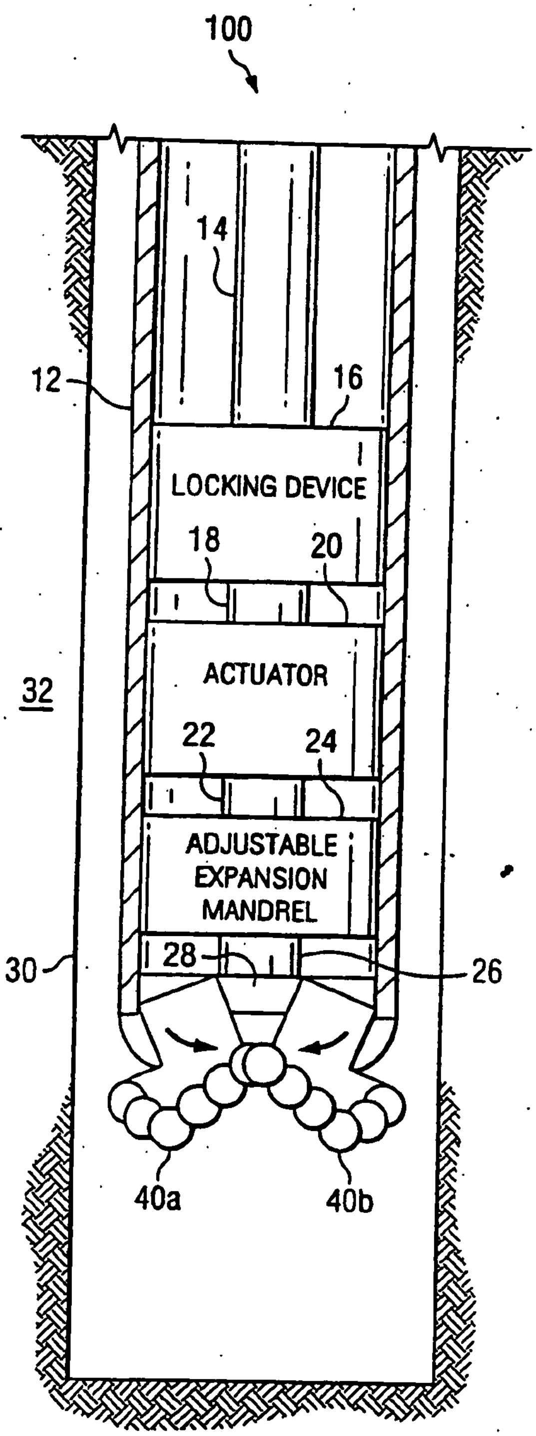
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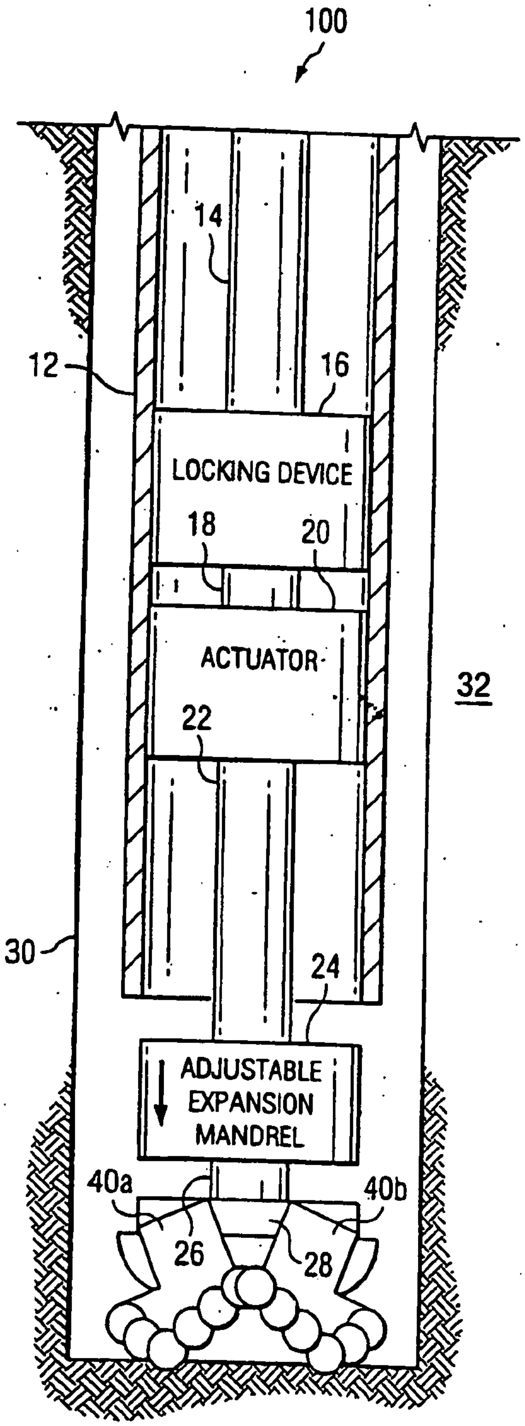
Fig. 8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EXPANSION
MANDREL
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Fig. 9

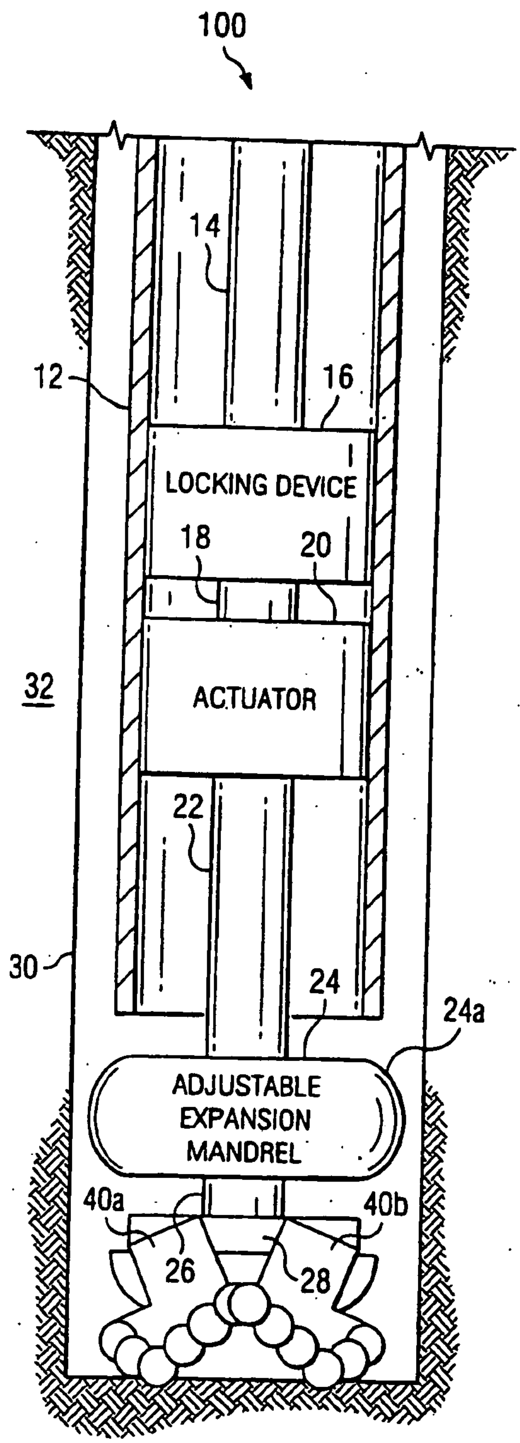
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Fig. 10

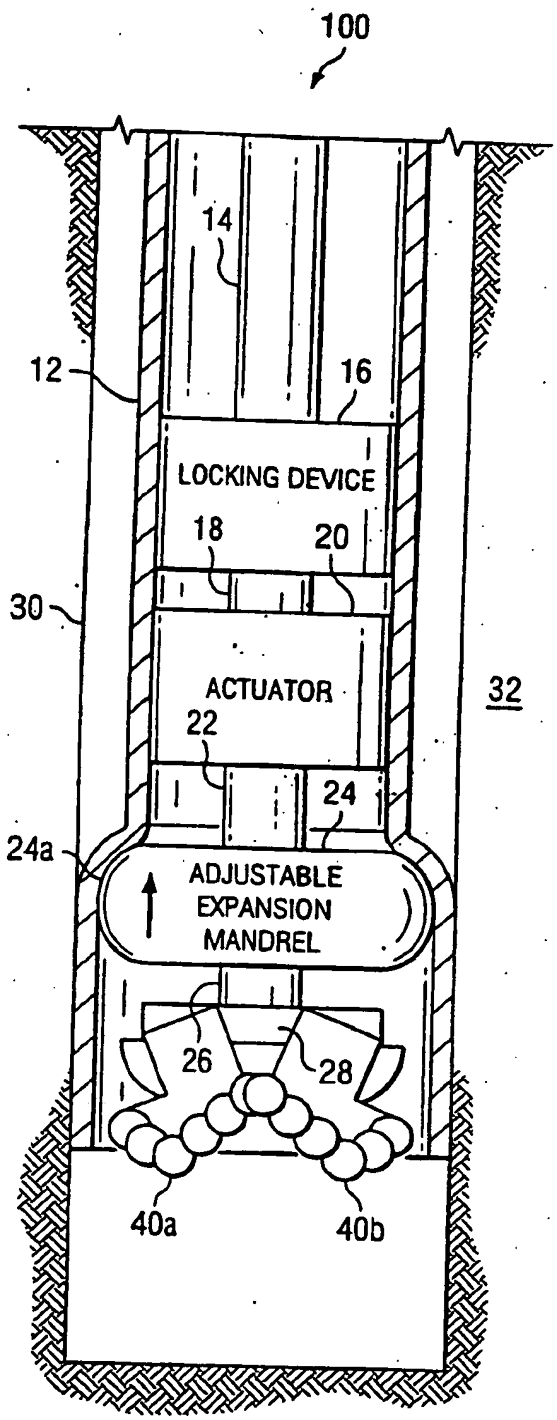
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Fig. 11

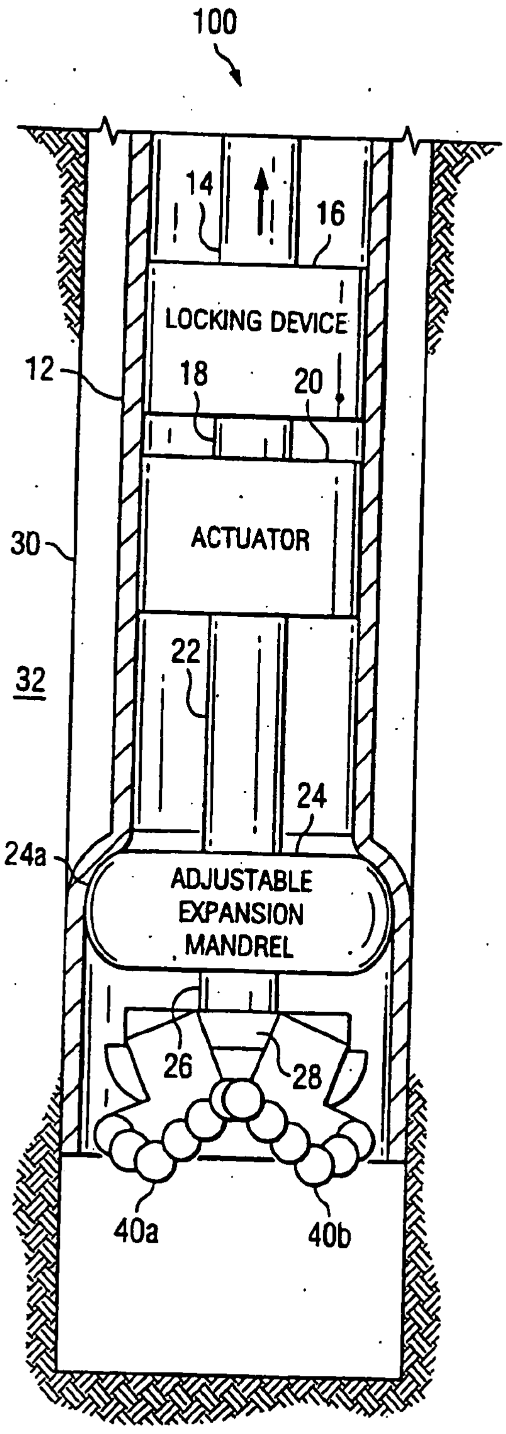
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Fig. 12

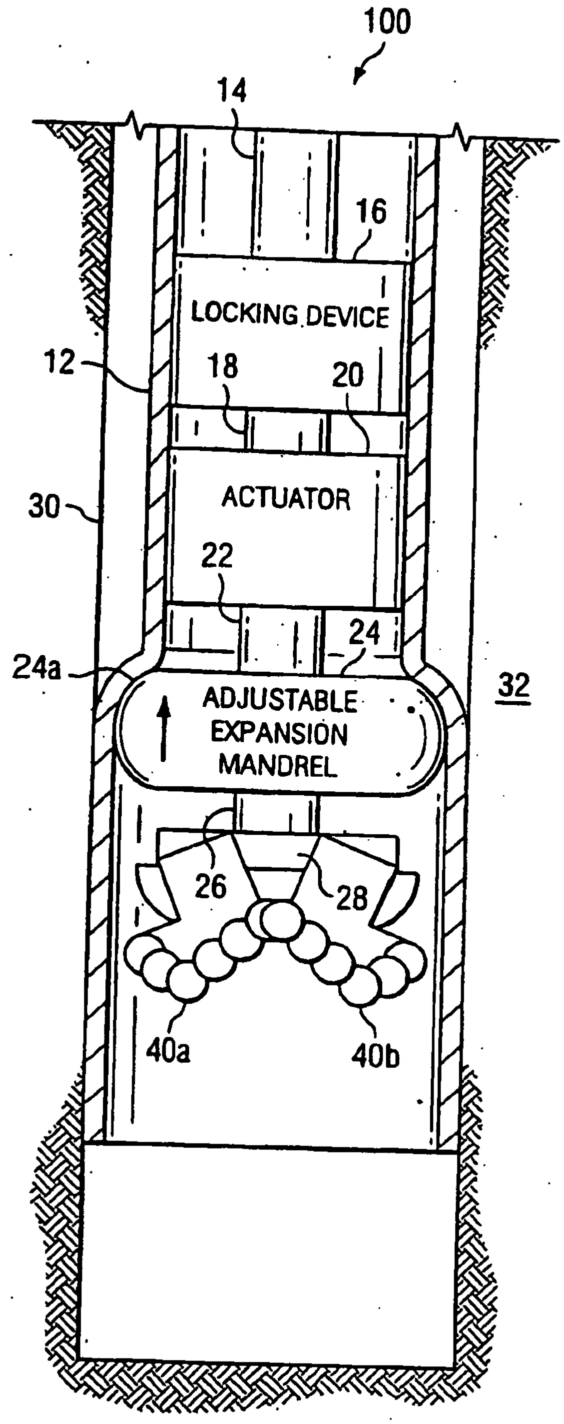
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Fig. 13

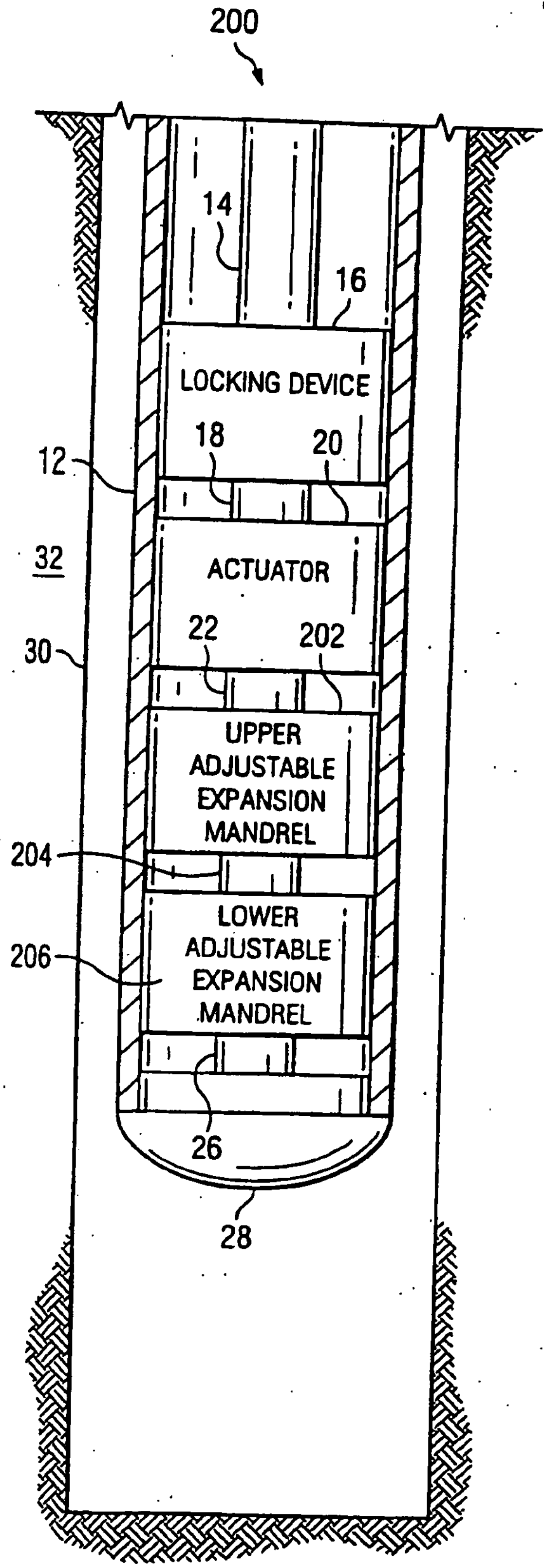
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Fig. 14

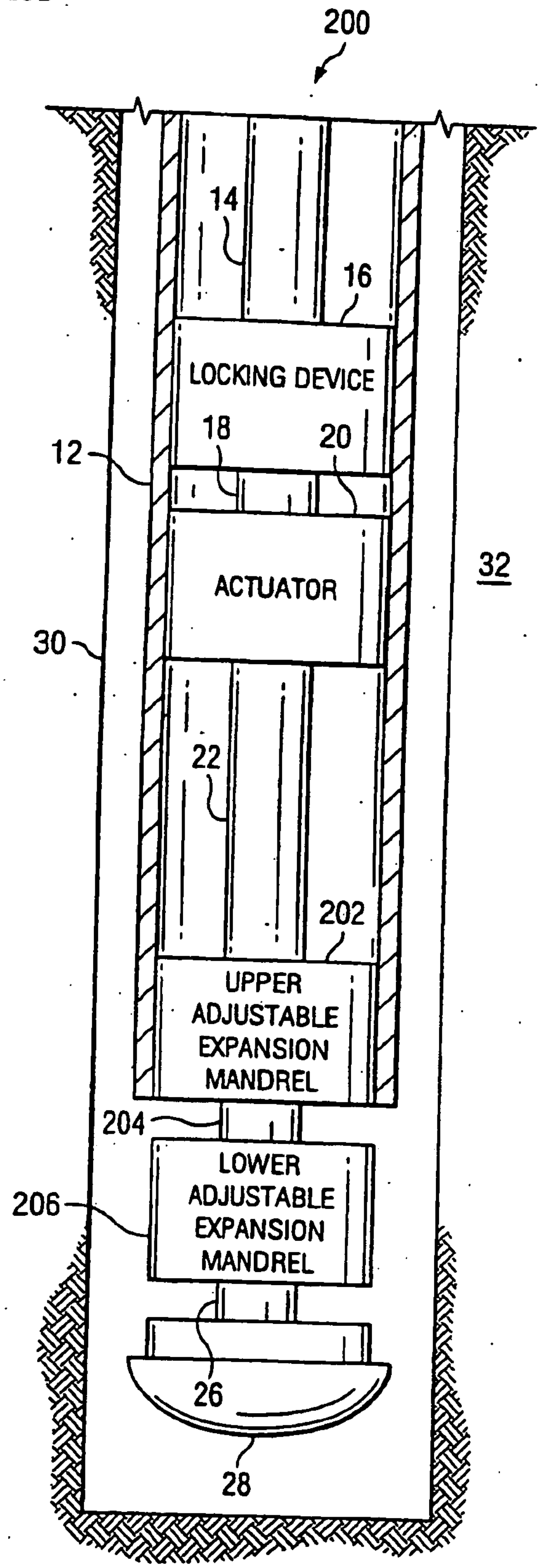
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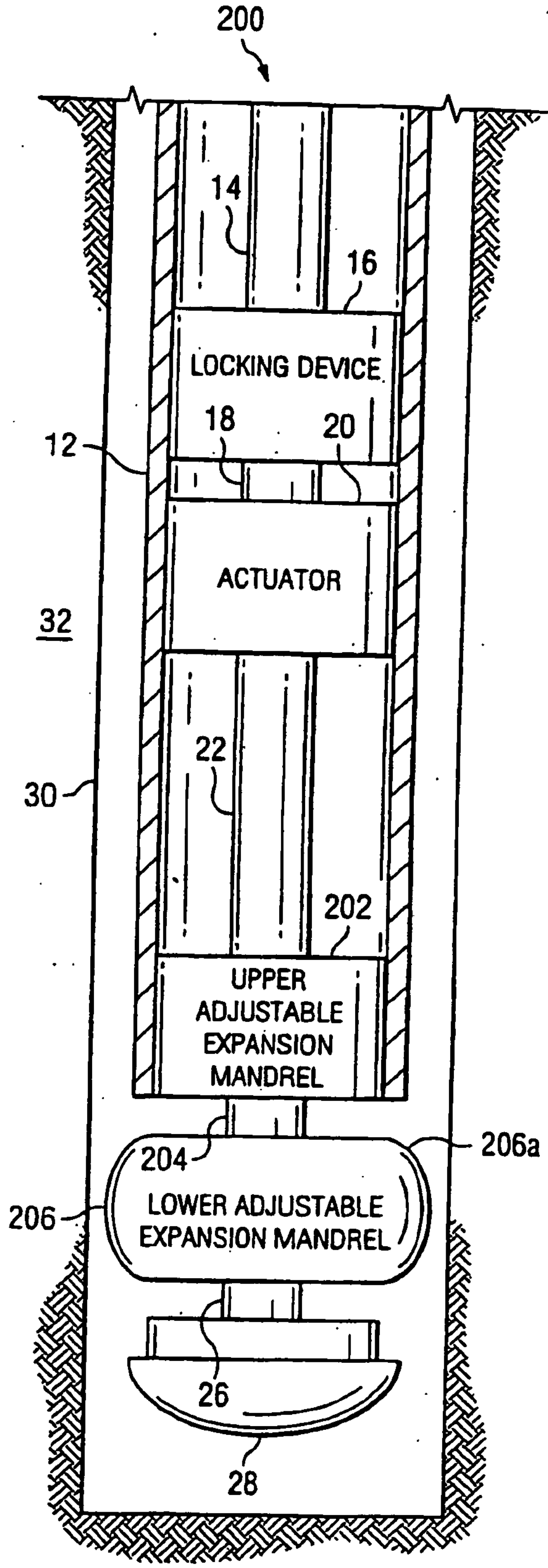
Fig. 15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LOWER ADJUSTABLE EXPANSION MANDREL
26
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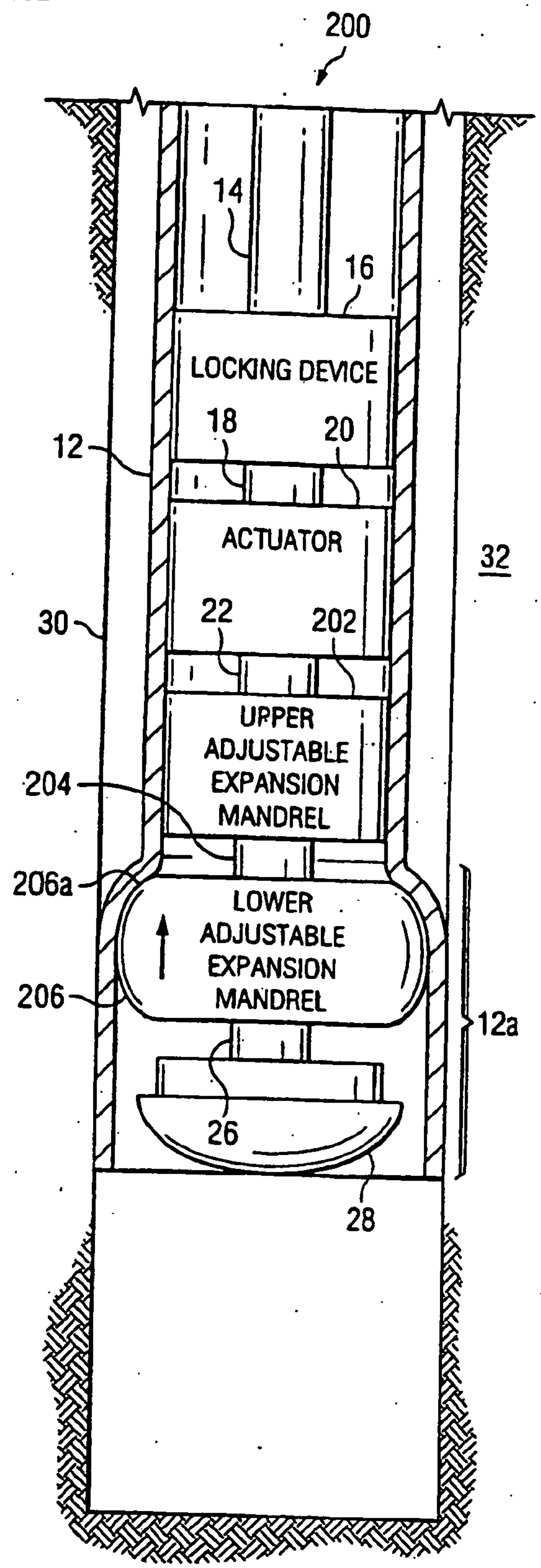
Fig. 16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206a
LOWER ADJUSTABLE EXPANSION MANDREL
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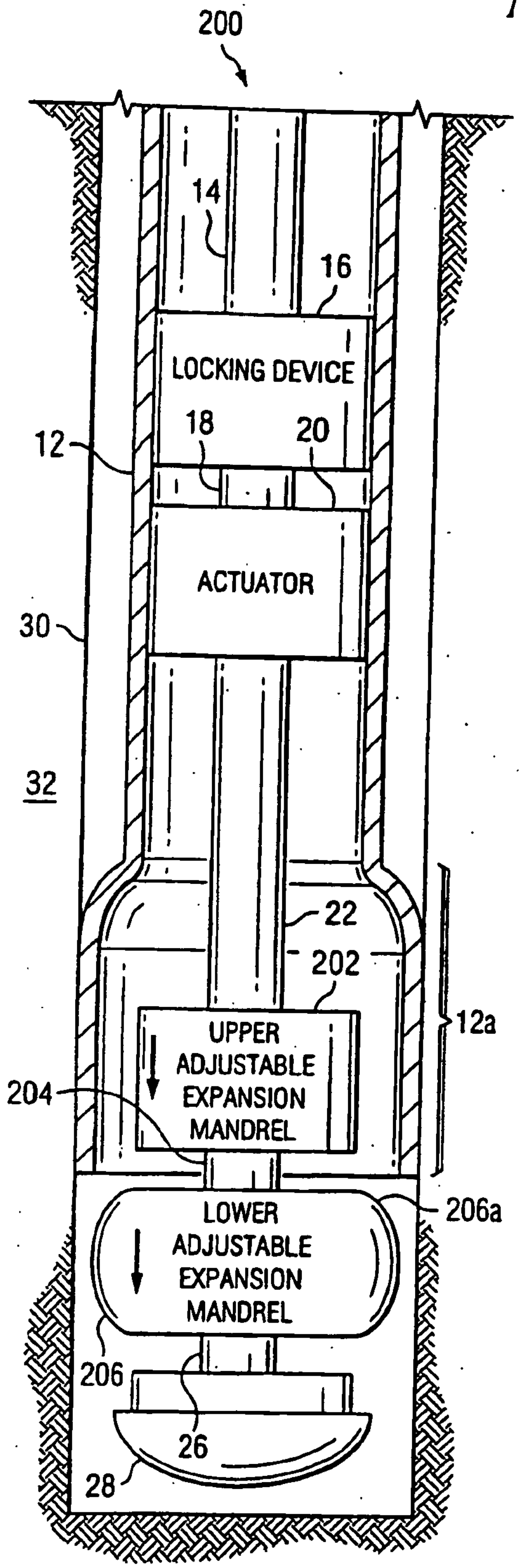
12a
26
28

Fig. 17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UPPER ADJUSTABLE EXPANSION MANDREL
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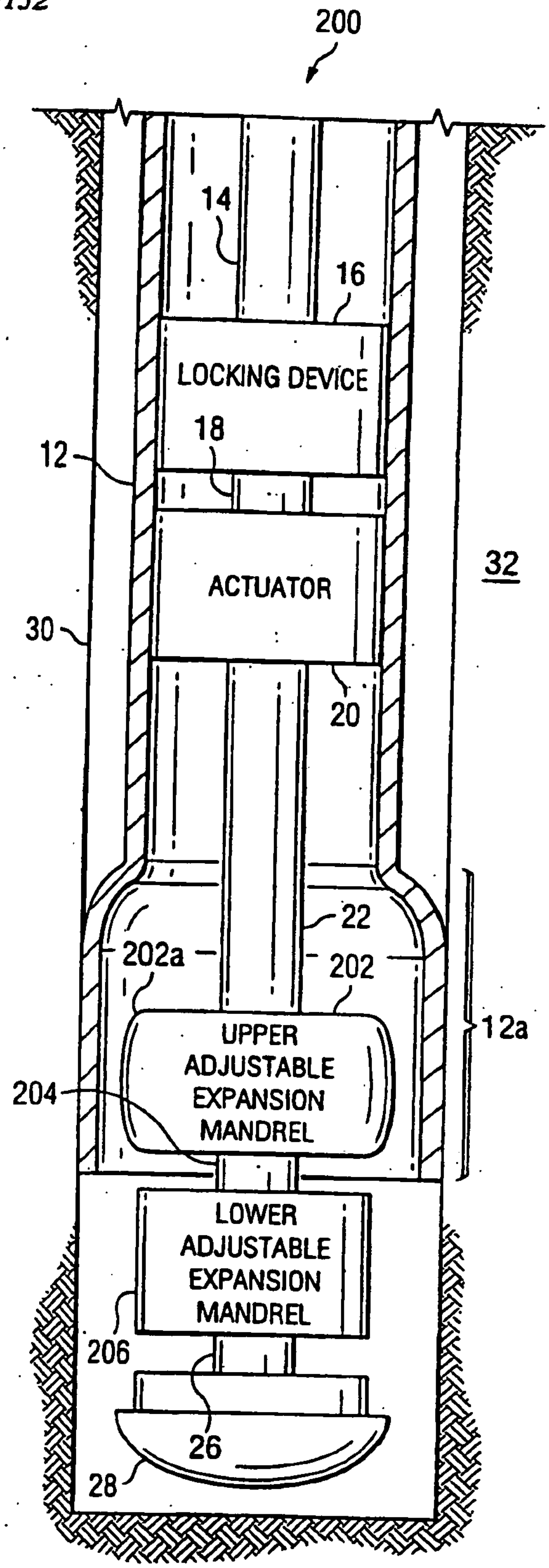
LOWER ADJUSTABLE EXPANSION MANDREL
206a
206
26
28

Fig. 18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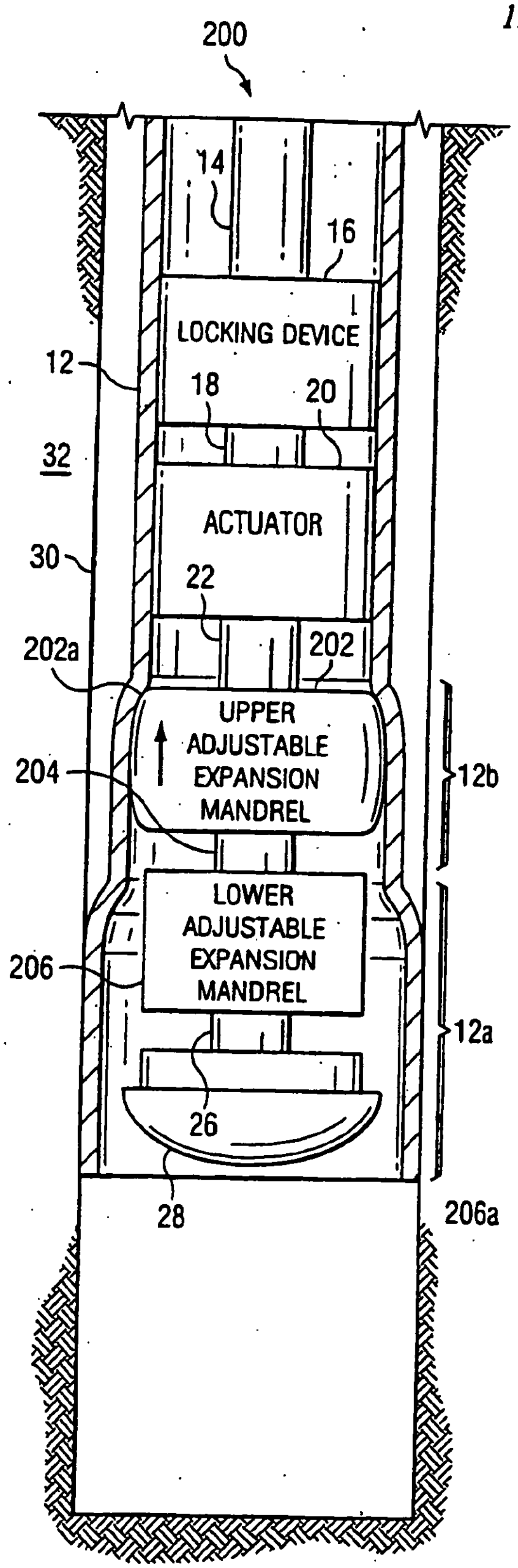
204
LOWER ADJUSTABLE EXPANSION MANDREL
206
26
28

Fig. 19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LOWER ADJUSTABLE EXPANSION MANDREL
206
12a
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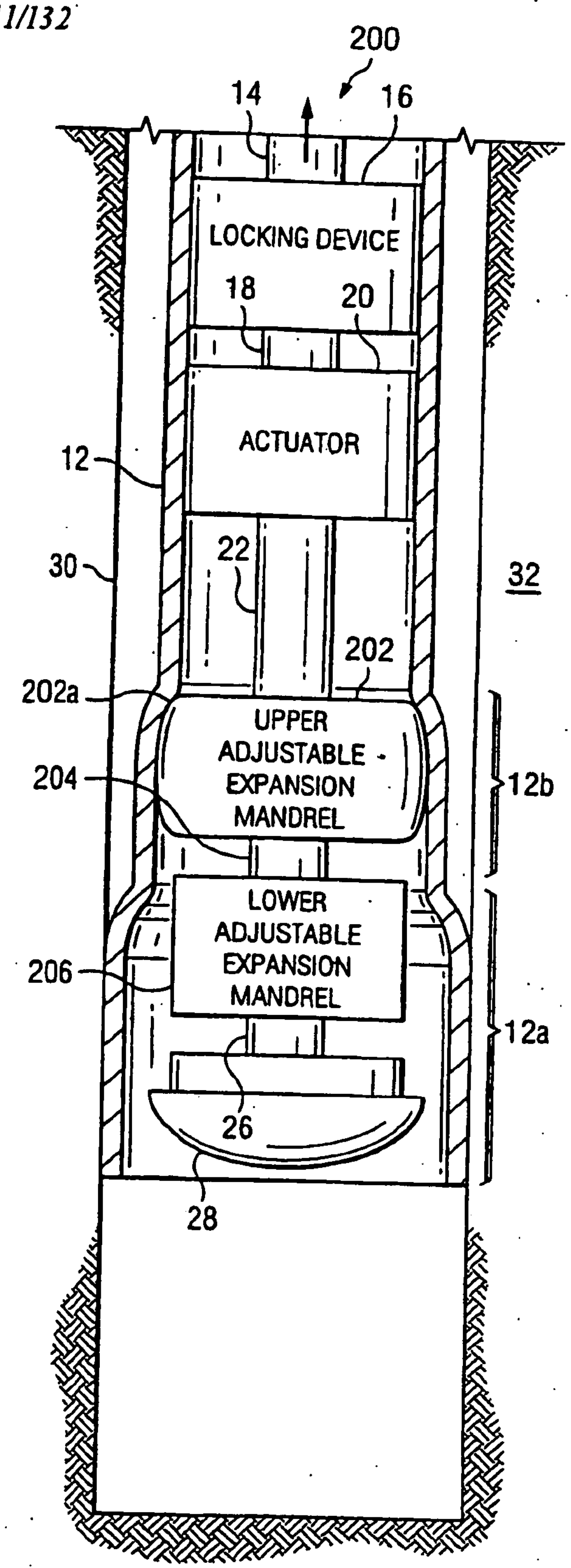
28
206a

Fig. 20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LOCKING DEVICE
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ACTUATOR
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30
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22
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202a
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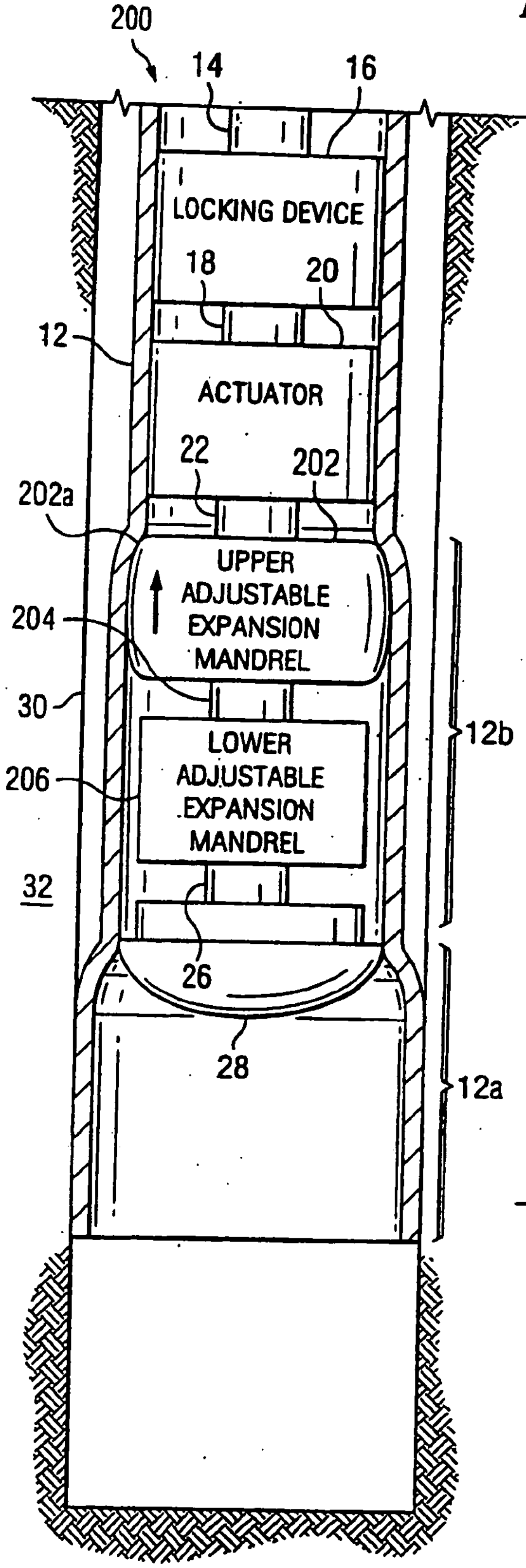
12b
LOWER ADJUSTABLE EXPANSION MANDREL
206
12a
26
28

Fig. 21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ACTUATOR
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202a
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LOWER ADJUSTABLE EXPANSION MANDREL
206
12b
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26
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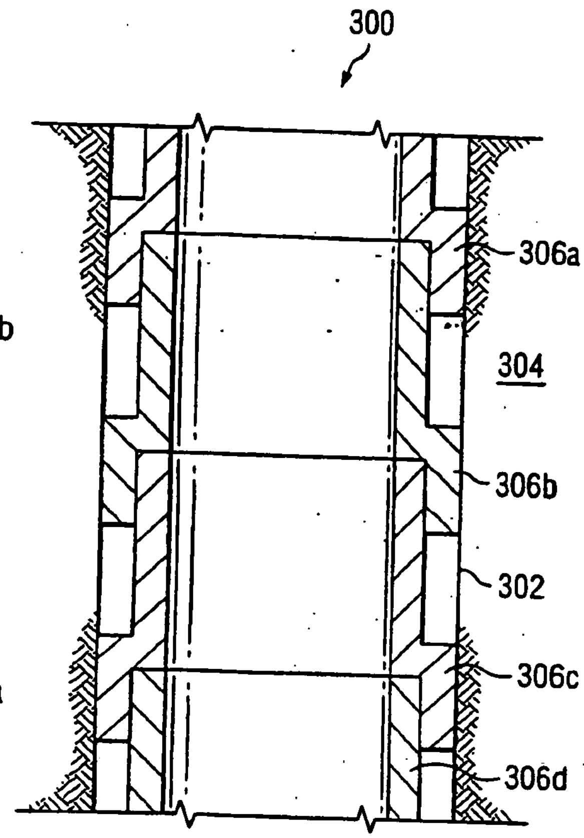
12a

Fig. 22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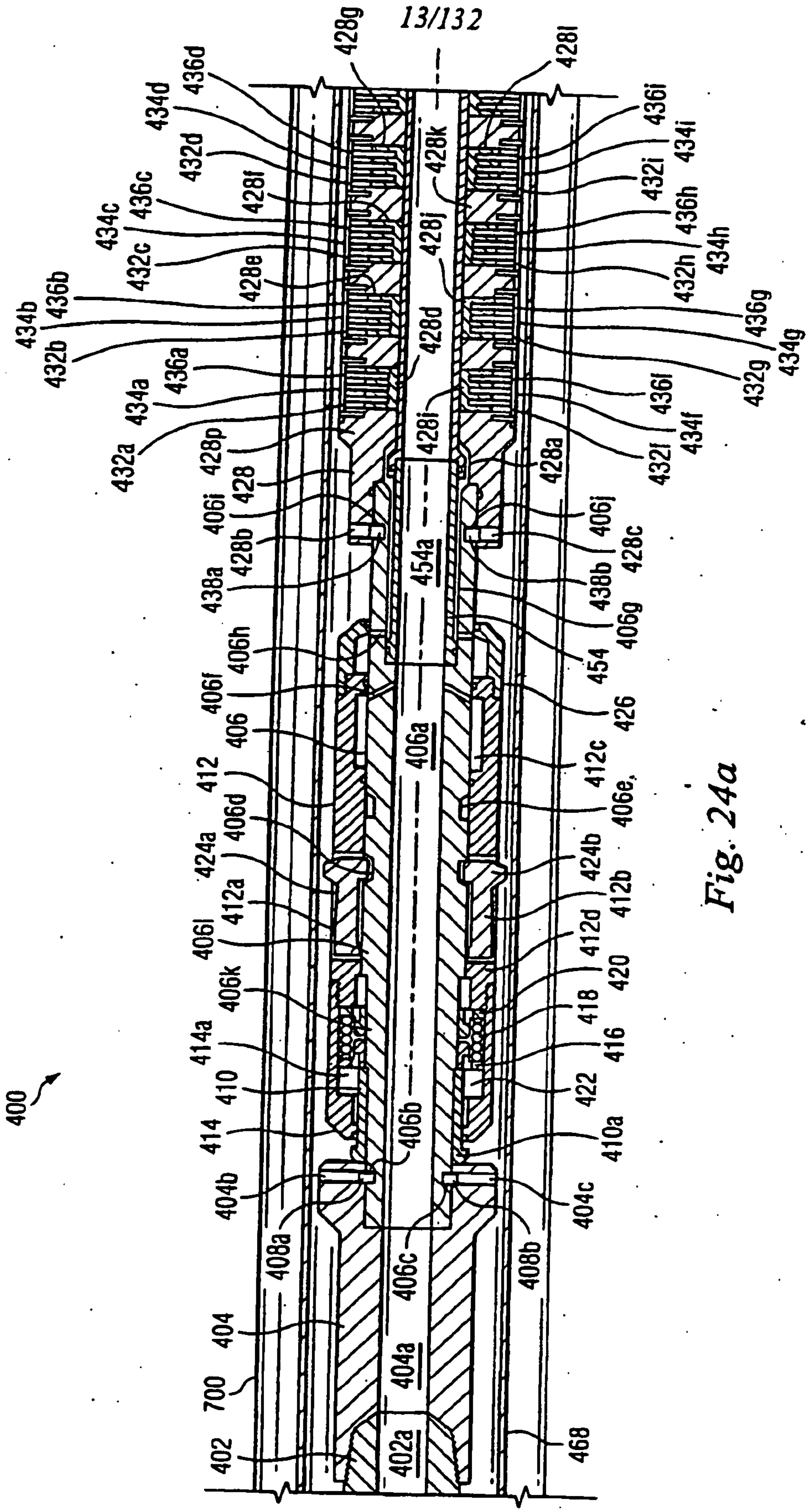
306c
306d

Fig. 23



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406i
406j
406k
406l
408a
408b
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410a
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412a
412b
412c
412d
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414a
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420
422
424a
424b
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428
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428e
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428g
428i
428j
428k
428l
428p
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432b
432c
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432h
432i
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434b
434c
434d
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434g
434h
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436i
438a
438b
454
454a
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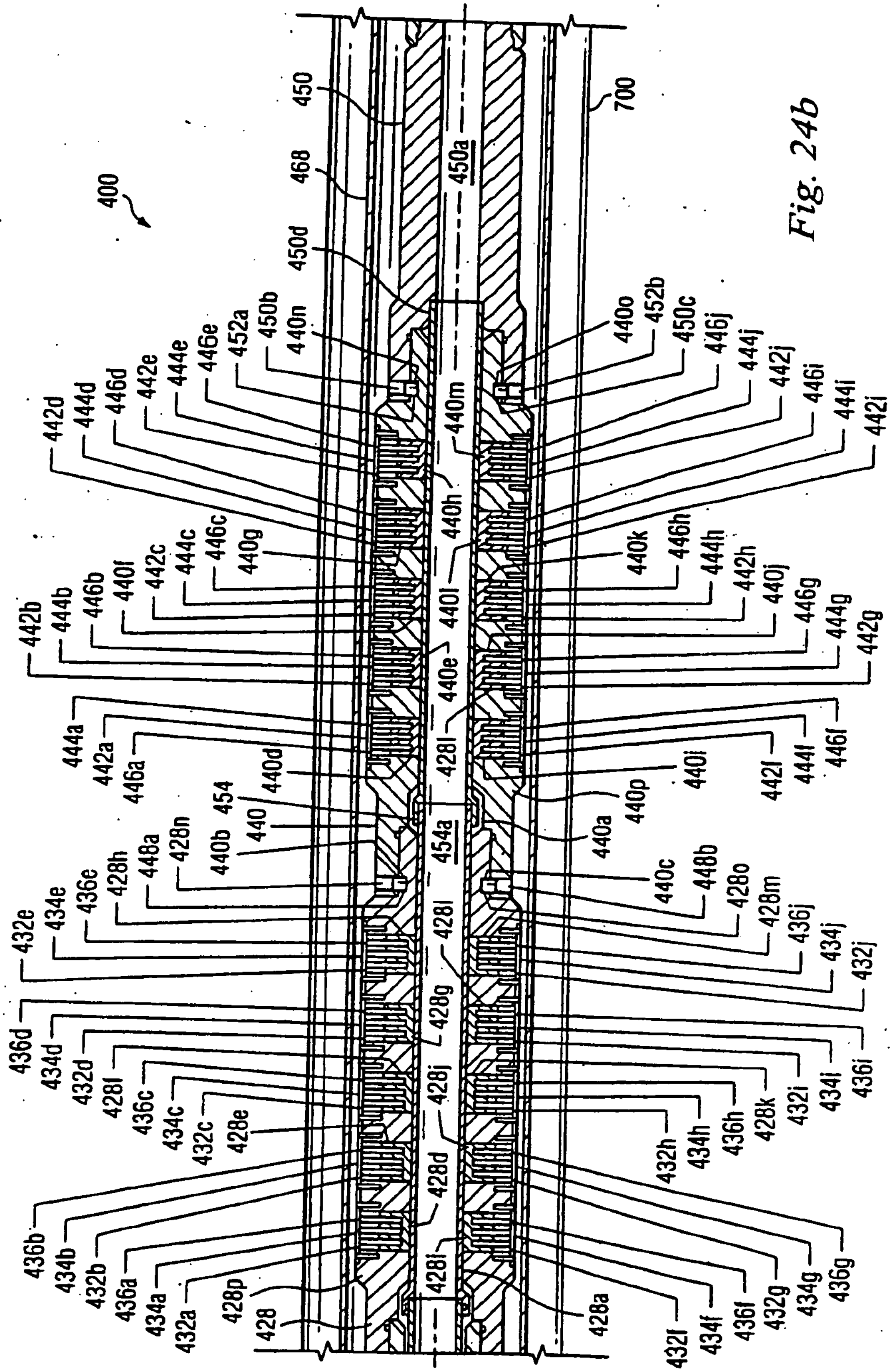
Fig. 24a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450c
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444j
442j
446i
444i
442i
440h
440g
446c
444c
442c
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446b
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440k
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428g
436d
434d
432d
428f
436c
434c
432c
428e
428j
436i
434i
432i
428k
436h
434h
432h
428d
436b
434b
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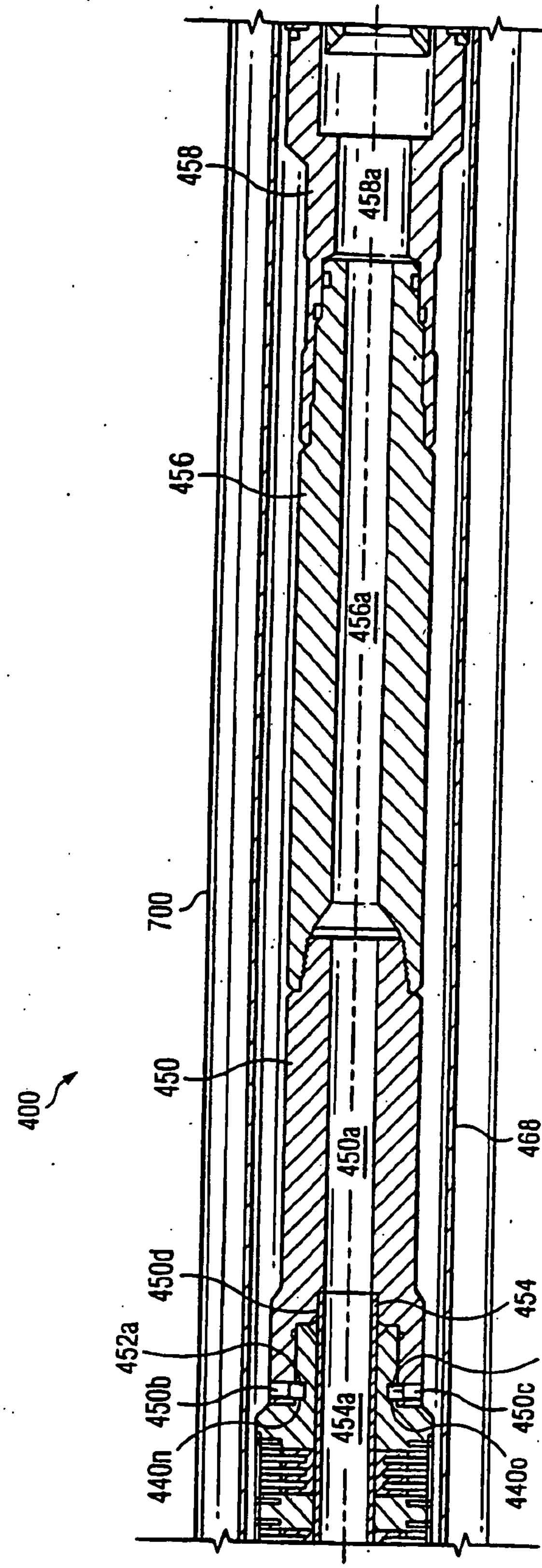
Fig. 24b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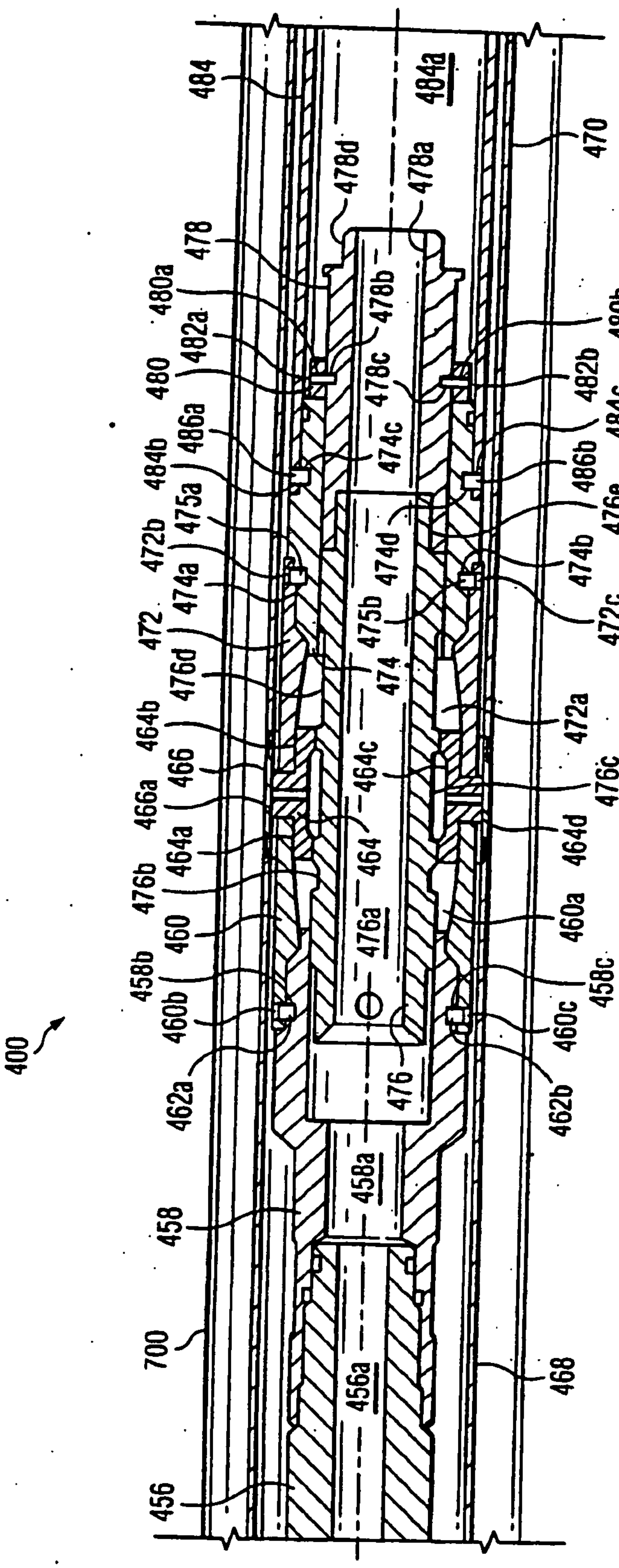
440o

Fig. 24c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486b
476e
475a
472b
474d
474b
474a
472
475b
472c
476d
474
472a
464b
464c
466
476c
466a
464a
464
464d
476b
460
476a
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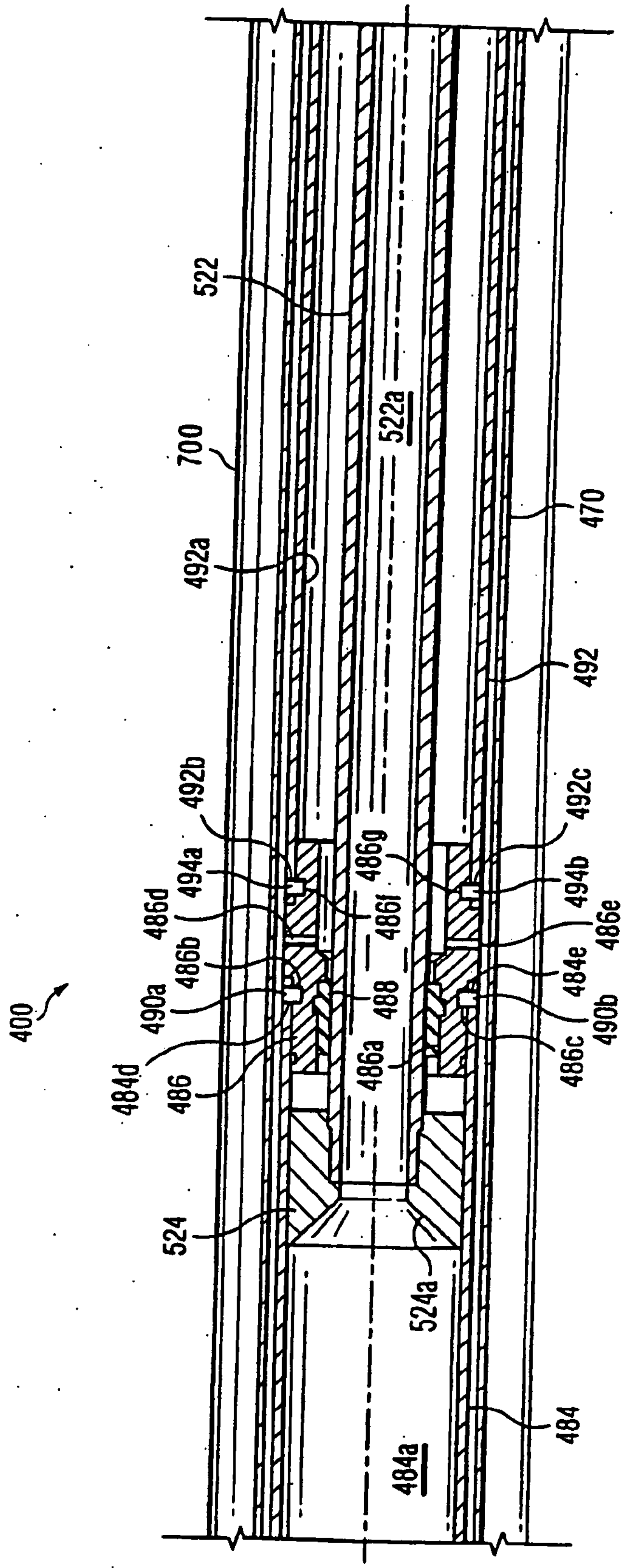
456a
468
456

Fig. 24d



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522a
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492a
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486d
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490a
484d
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486a
492c
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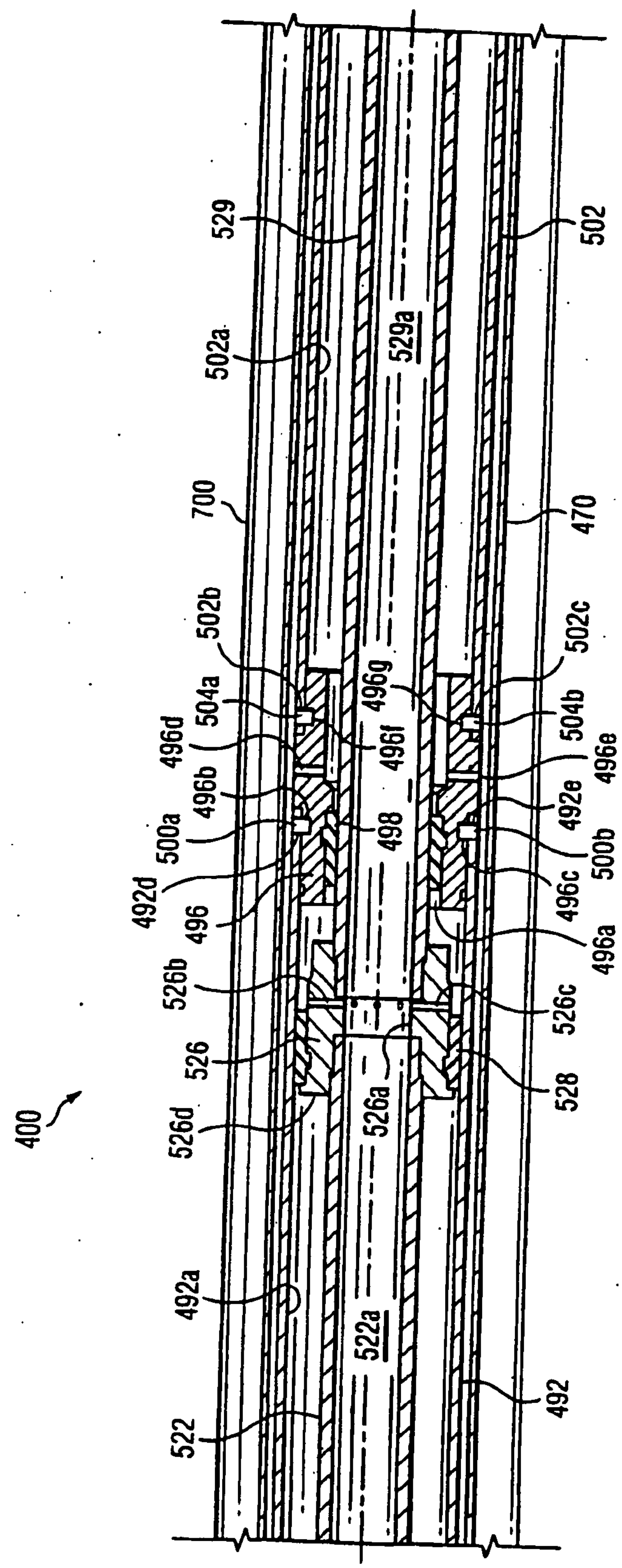
486c
524
524a
484
484a

Fig. 24e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498
500b
492d
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496a
526b
526c
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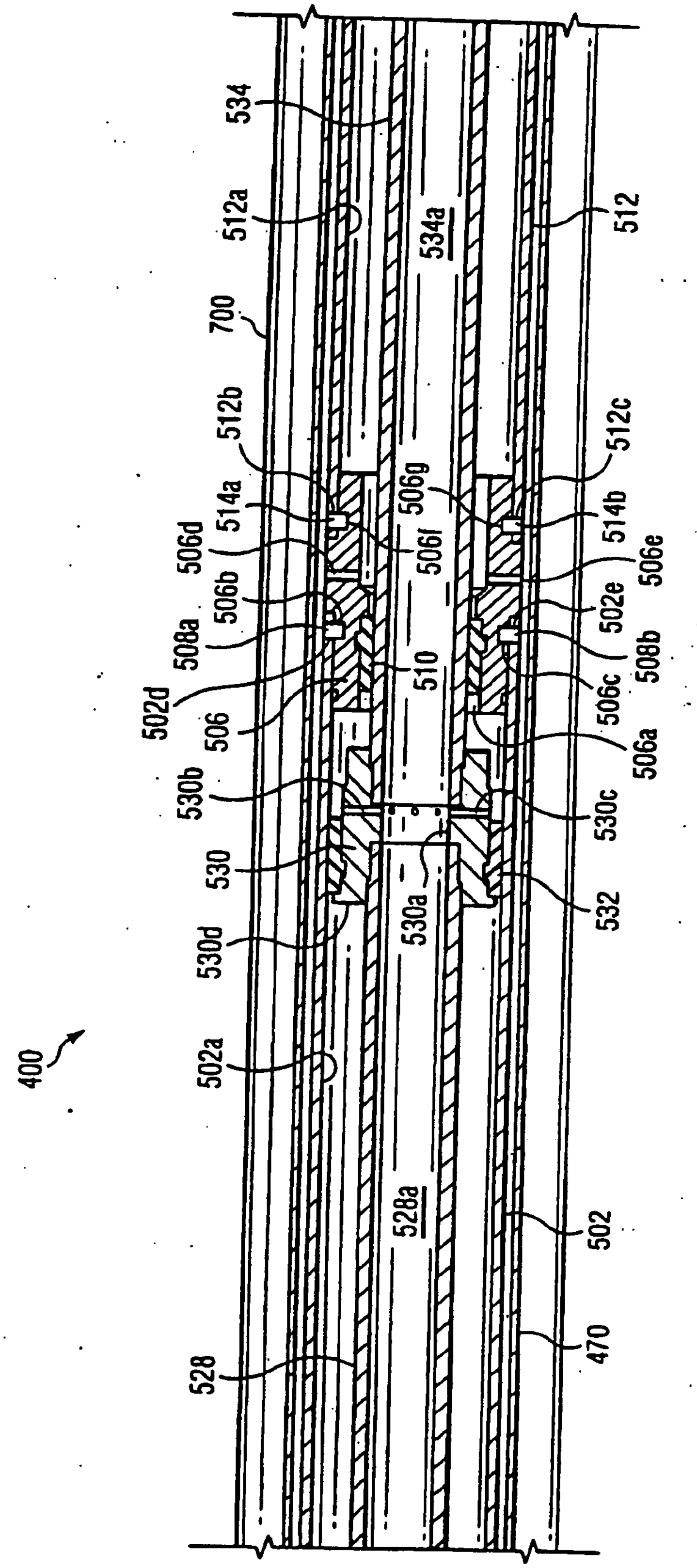
526a
526d
400
492a
522a
522
492

Fig. 24f



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502d
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530b
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530d
502a
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534a
506g
506f
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514b
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502e
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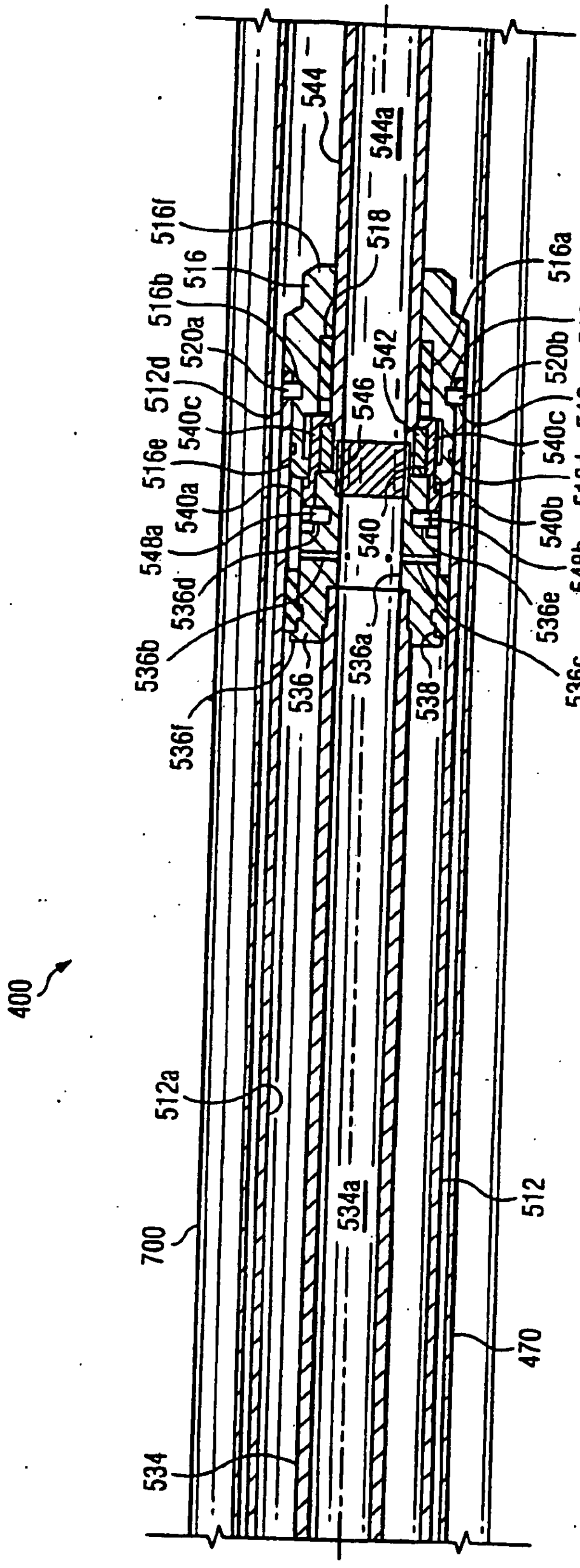
506c
506a
530c
532
502
470

Fig. 24g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516a
516c
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540b
548b
536e
536c
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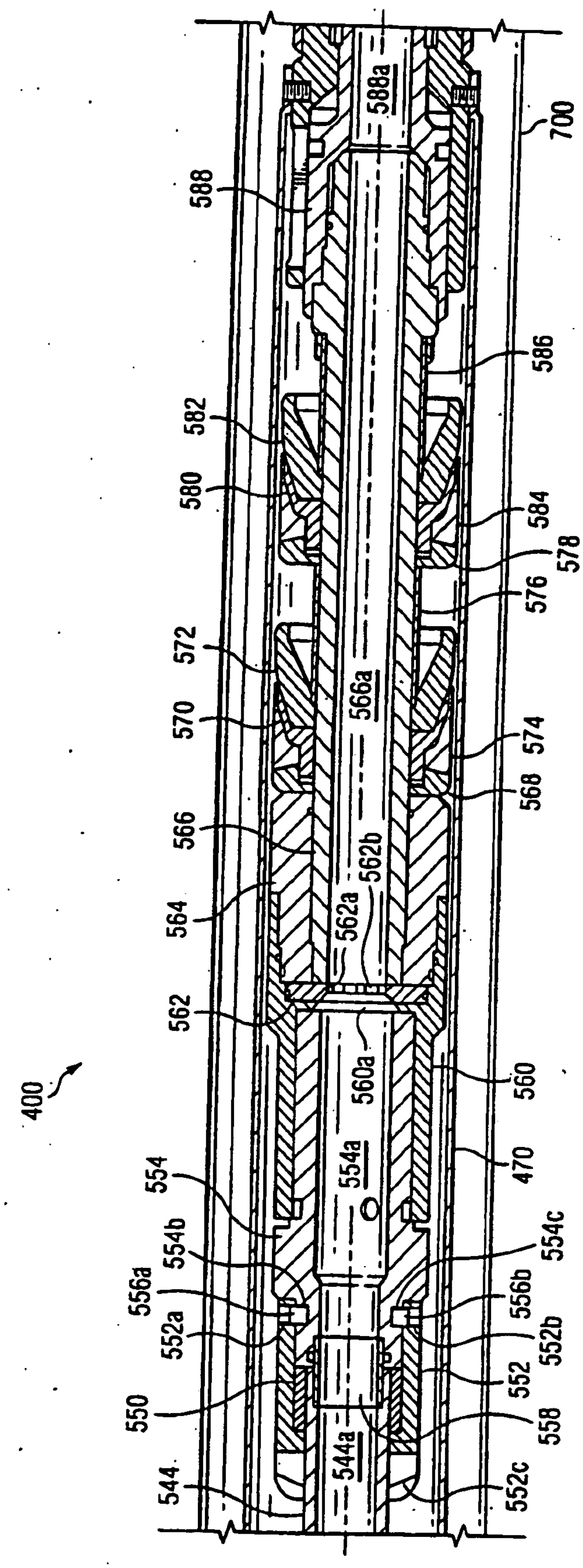
512a
700
534a
512
470
534

Fig. 24h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556b
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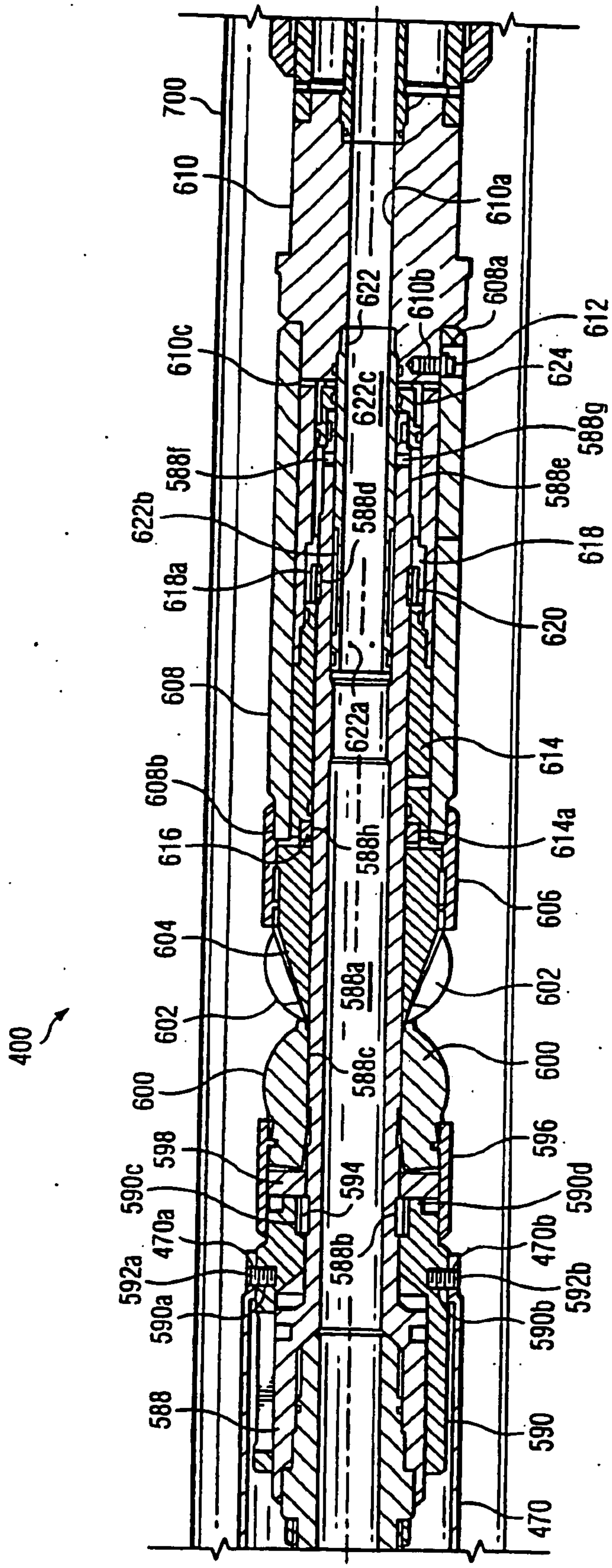
552b
550
552
558
544a
544
552c

Fig. 24i



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588e
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622a
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608b
614a
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588a
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588c
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Fig. 24j

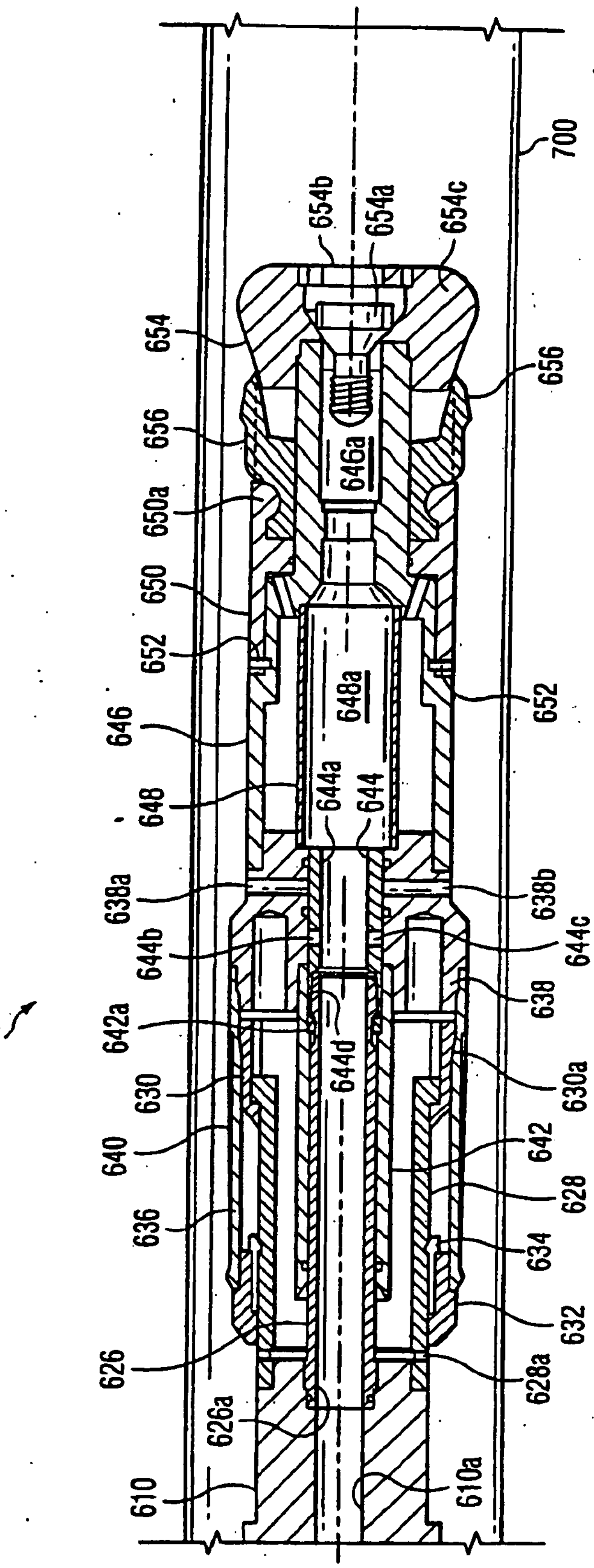

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Fig. 24k

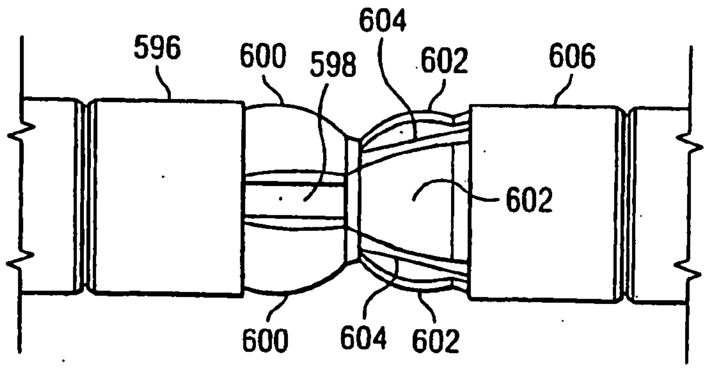


Fig. 25a

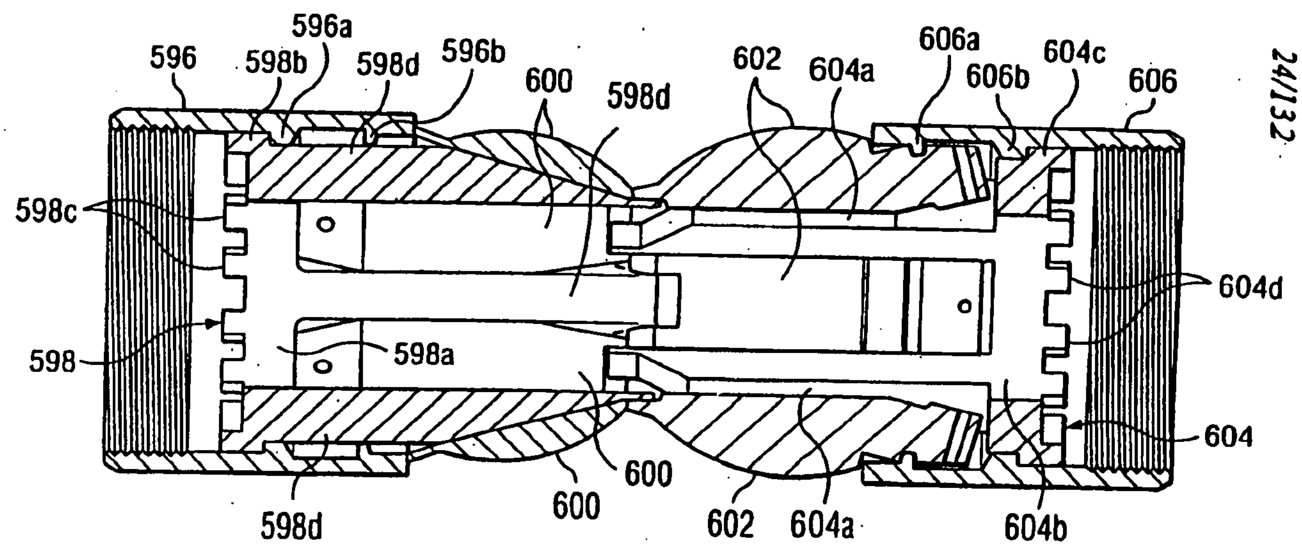


FIG. 25b

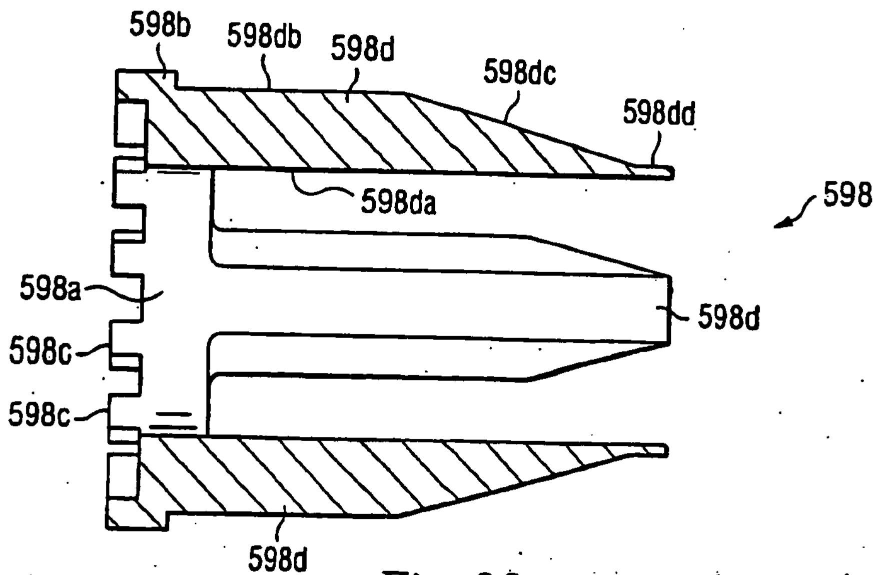


Fig. 25c

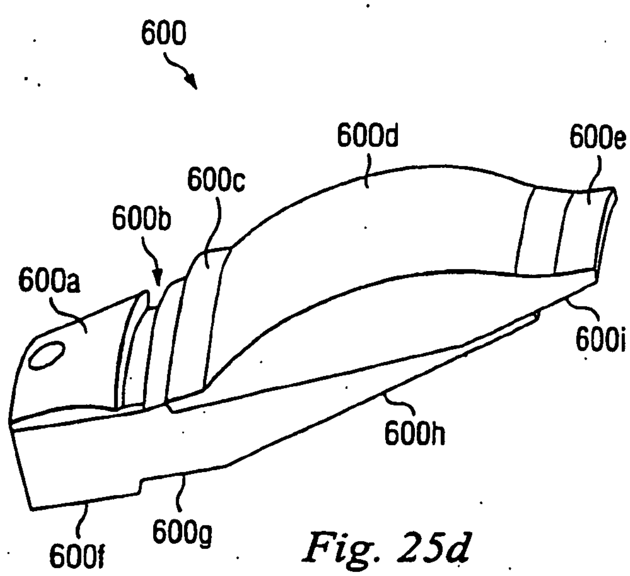


Fig. 25d

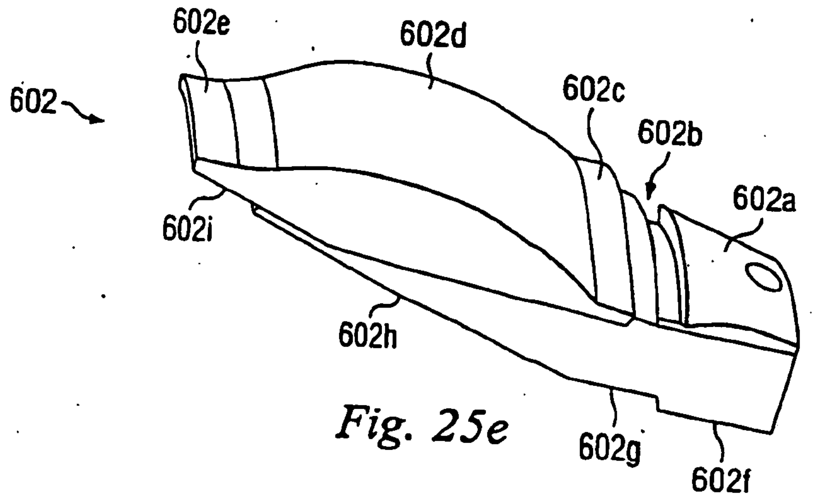


Fig. 25e

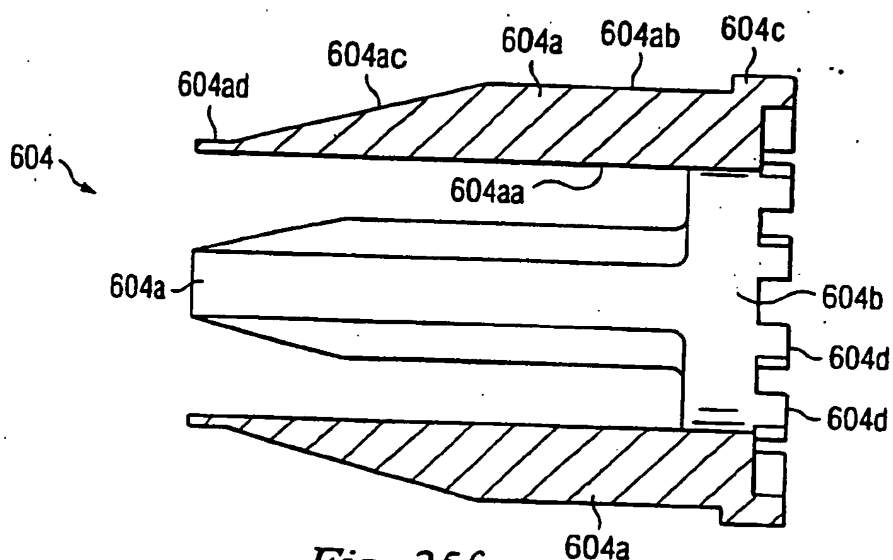


Fig. 25f

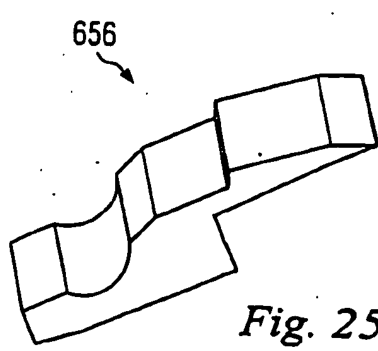
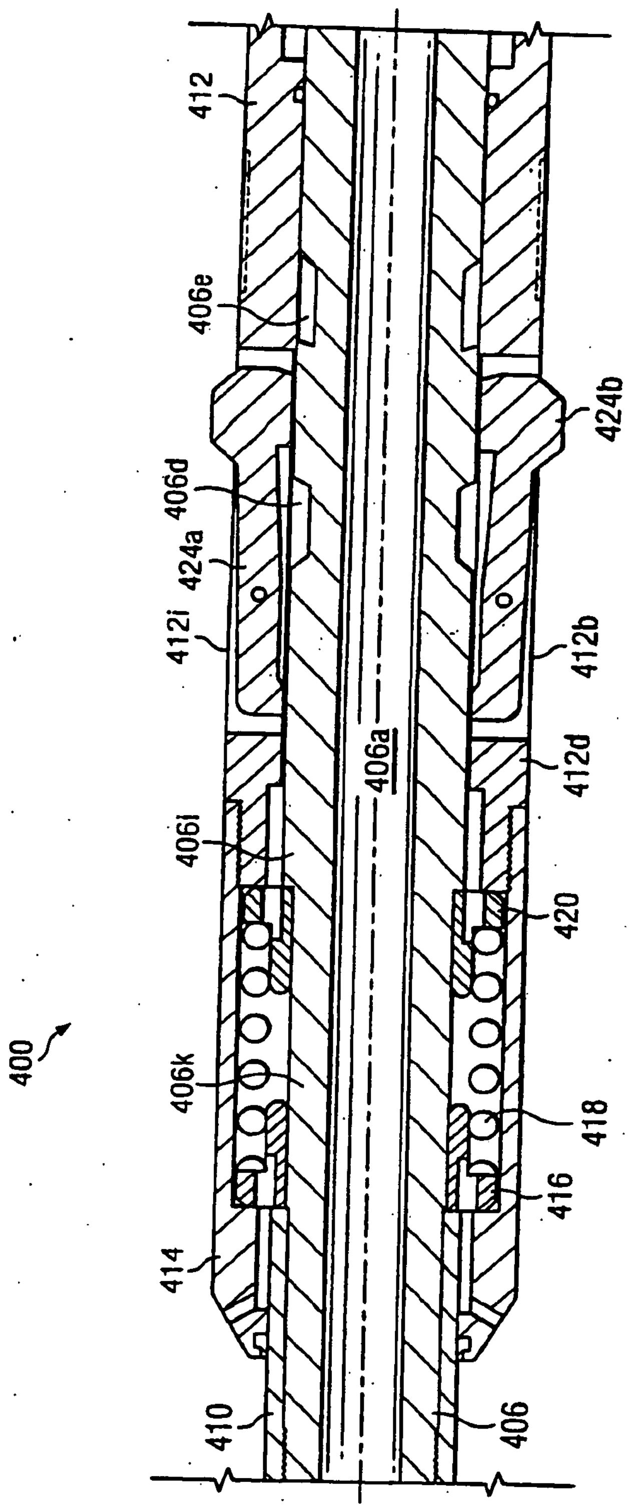


Fig. 25g


412
406e
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406k
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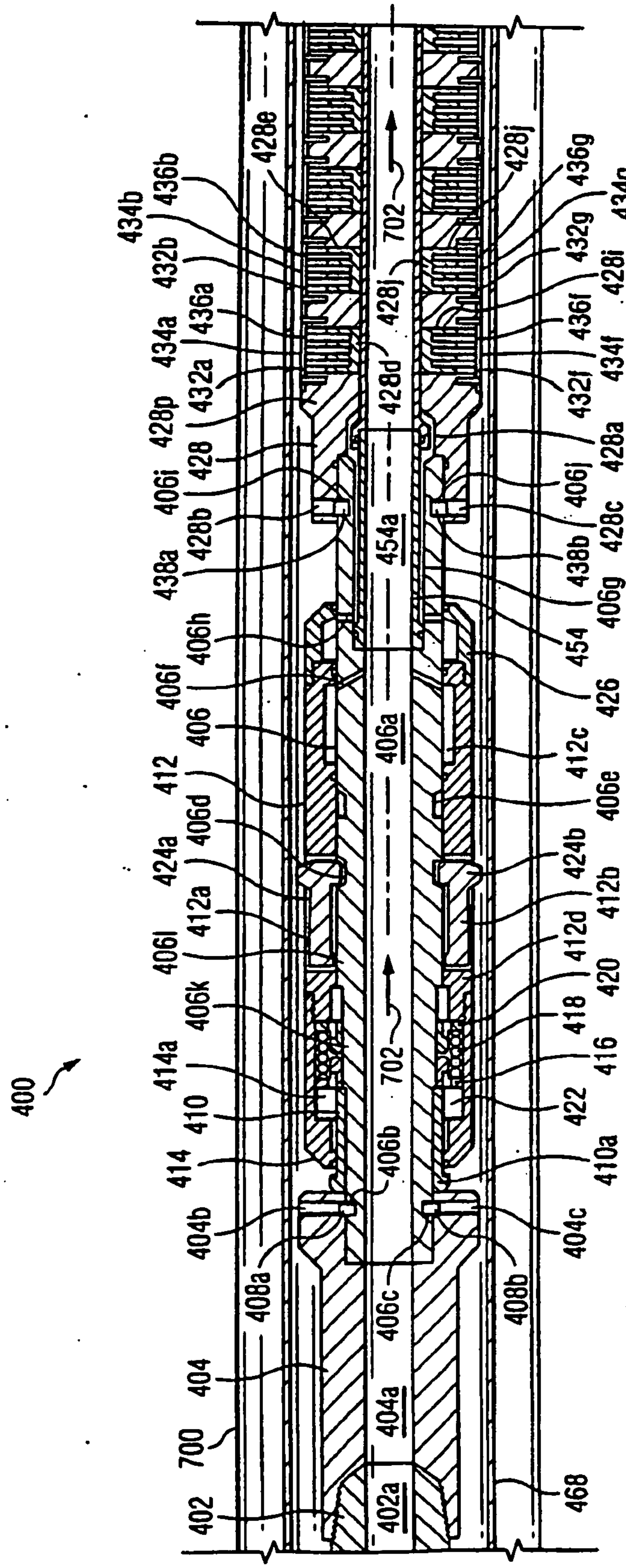
410
406

Fig. 25h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424a
406d
412a
406l
406k
414a
410
414
404b
408a
404
700
402
402a
404a
406c
406b
702
406a
454a
428d
428j
702
428j
436g
434g
432g
428i
436f
434f
432f
428a
406j
428c
438b
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412d
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422
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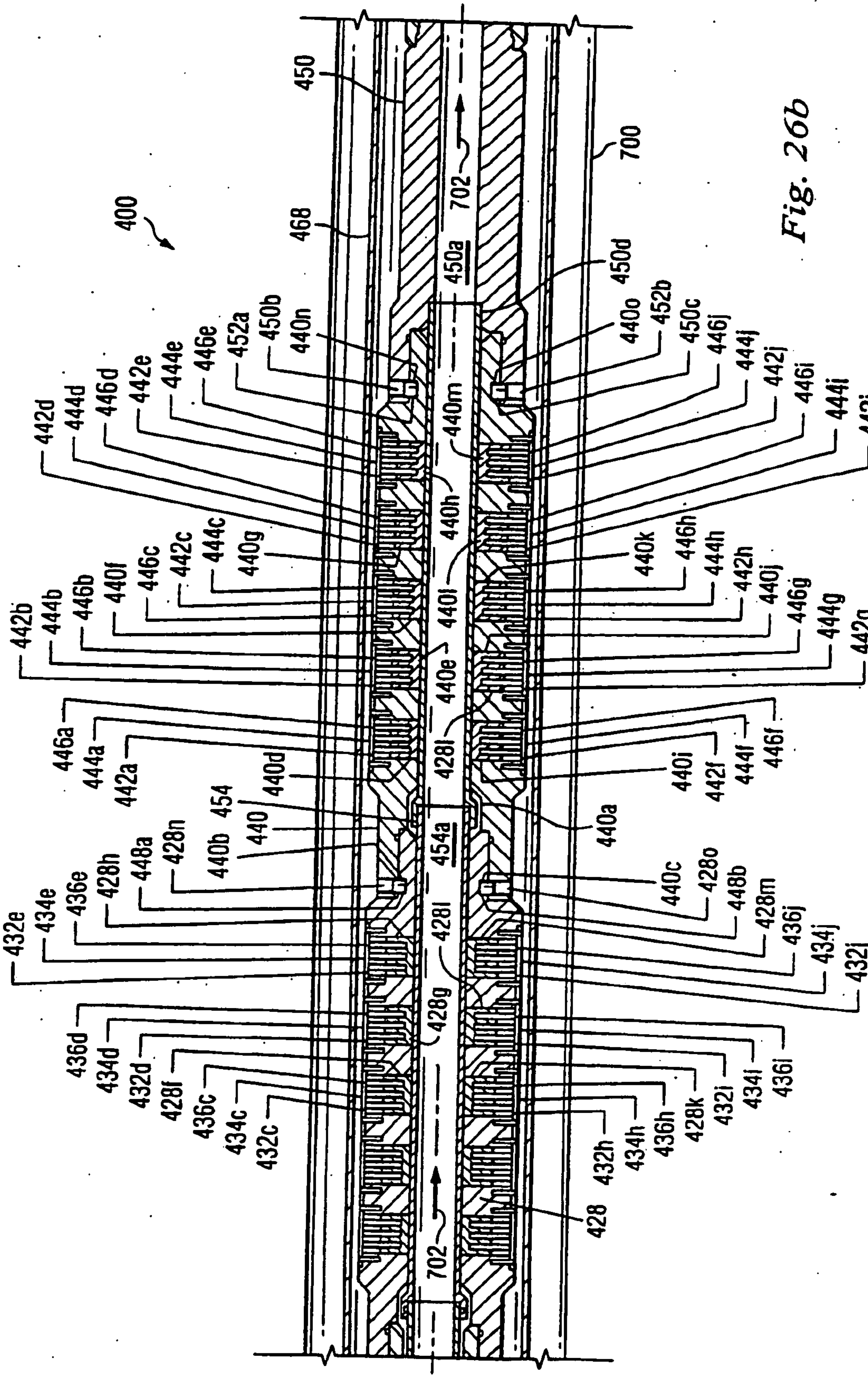
404c
408b
468

Fig. 26a



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450c
446j
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446i
444i
442i
446e
444e
442e
446d
444d
442d
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440h
440g
444c
442c
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440f
446b
444b
442b
440k
446h
444h
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440j
446g
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442g
440l
440e
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444a
442a
440d
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440b
454a
440a
440i
442f
444f
446f
448a
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428h
436e
434e
432e
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428m
436j
434j
432j
428g
436d
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436c
434c
432c
436i
434i
432i
428k
436h
434h
432h
428

Fig. 26b

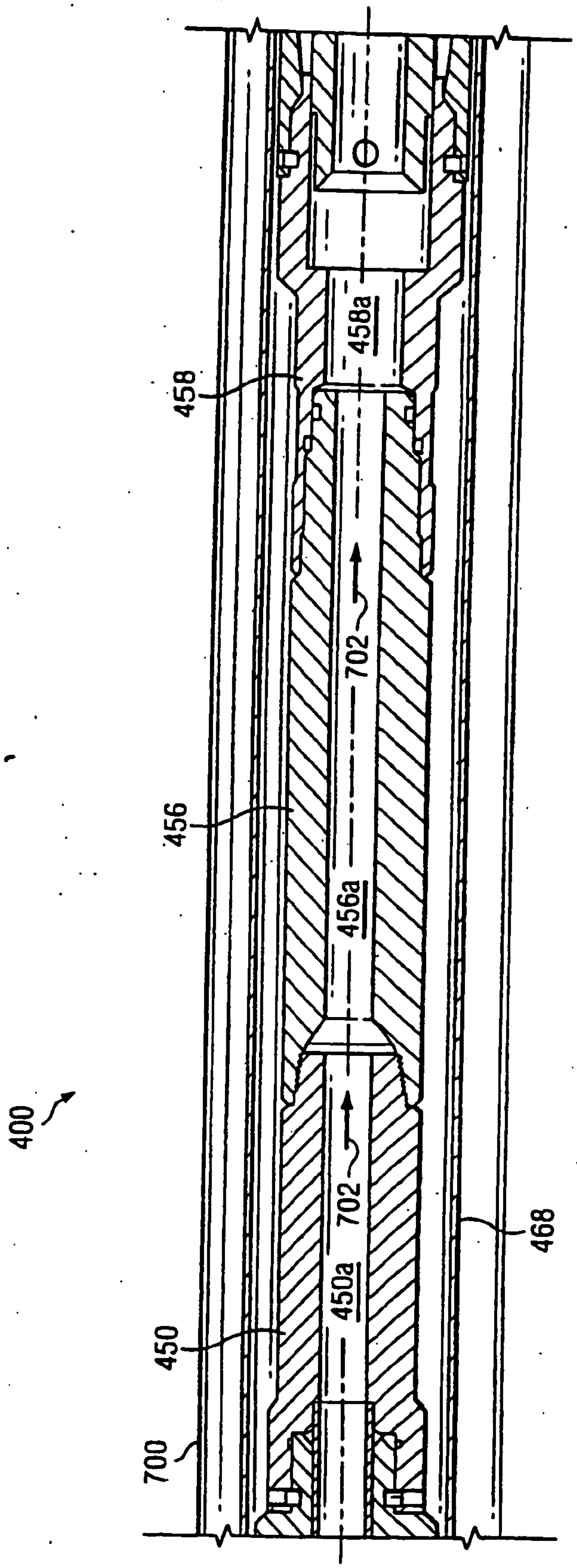
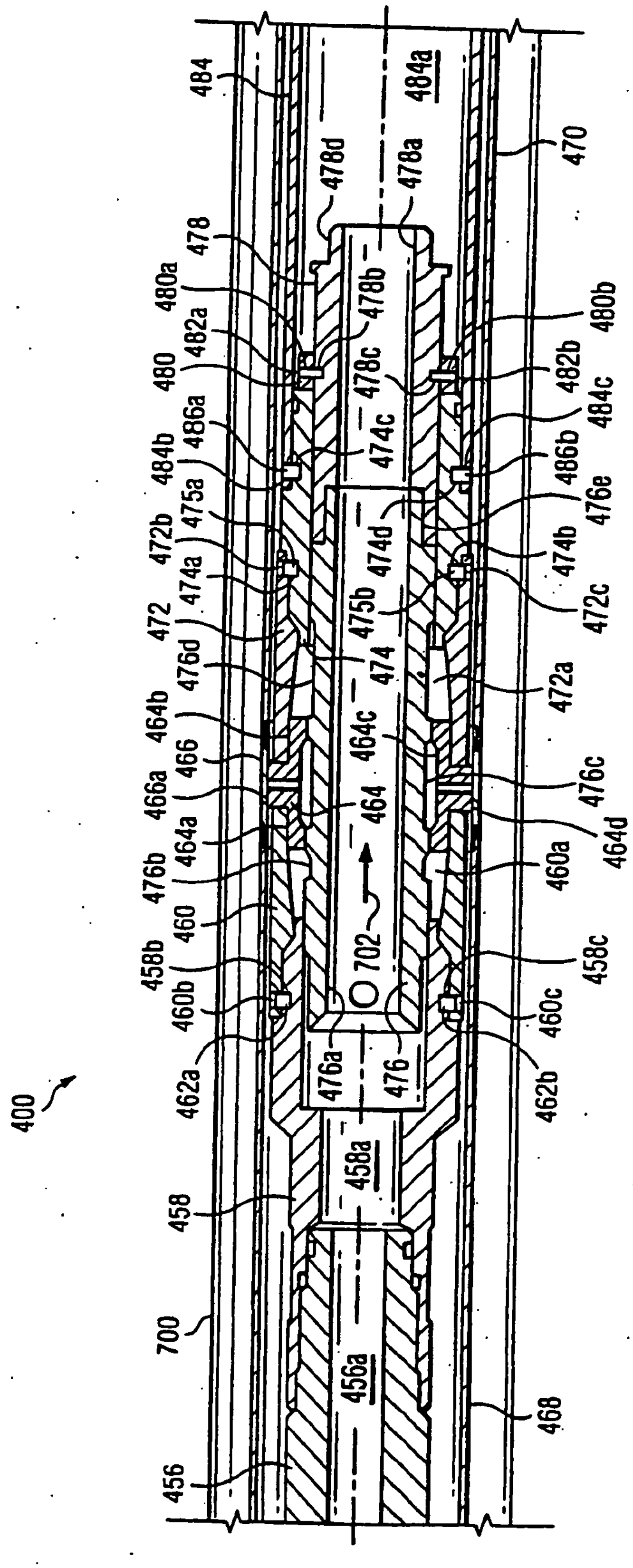


Fig. 26c



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484
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478b
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480
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466a
464
464a
464d
476b
460a
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476
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462b
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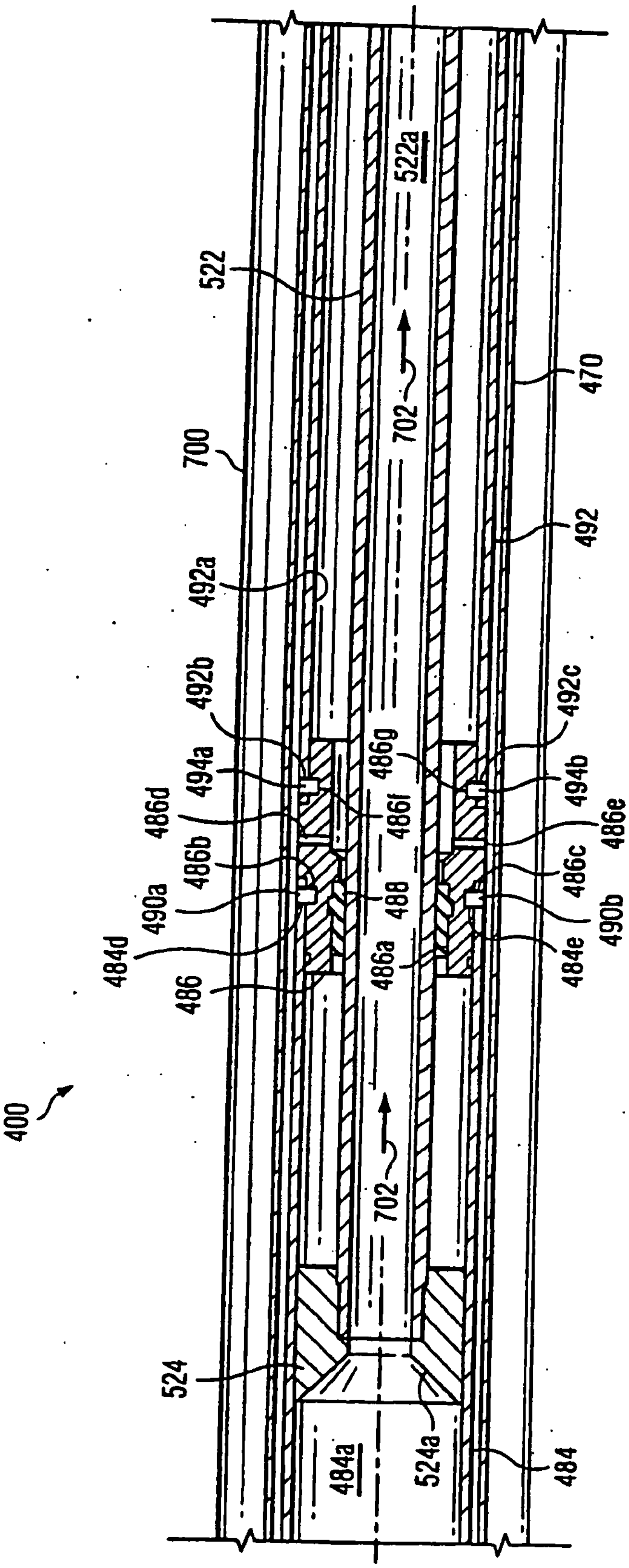
458
700
456a
468
456

Fig. 26d



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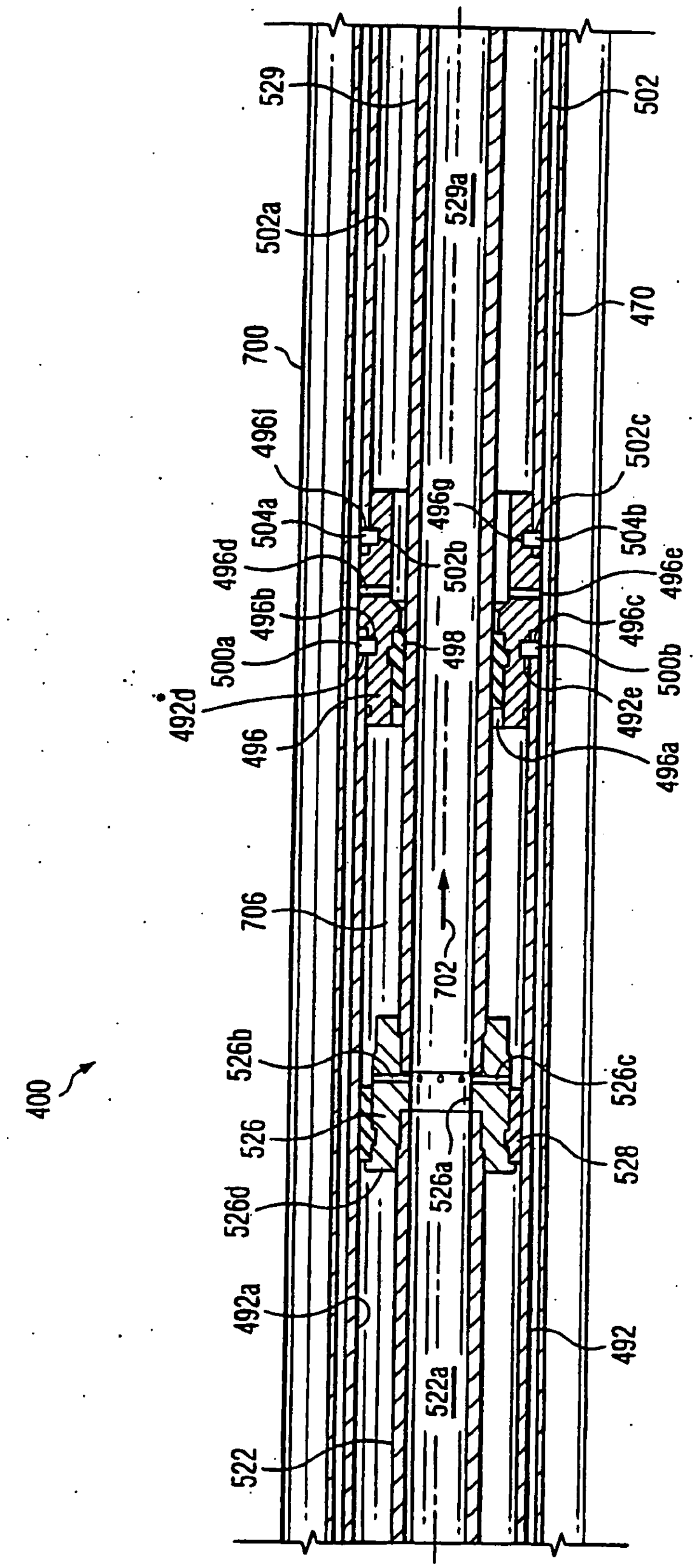
484e
524
524a
484a
484

Fig. 26e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502a
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496
706
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526
526d
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522
529a
502b
498
702
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522a
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496g
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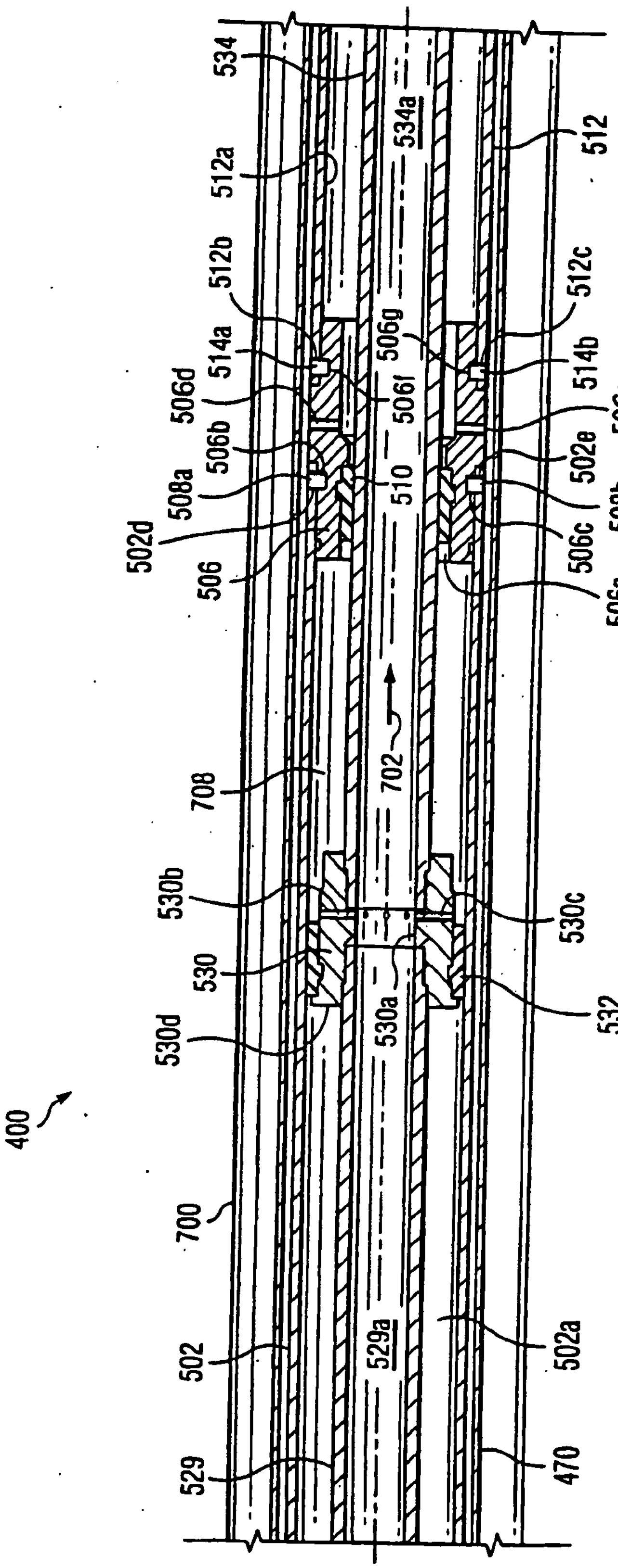
496e
496c
500b
492e
496a
526c
528
492

Fig. 26f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508b
502d
506c
506
506a
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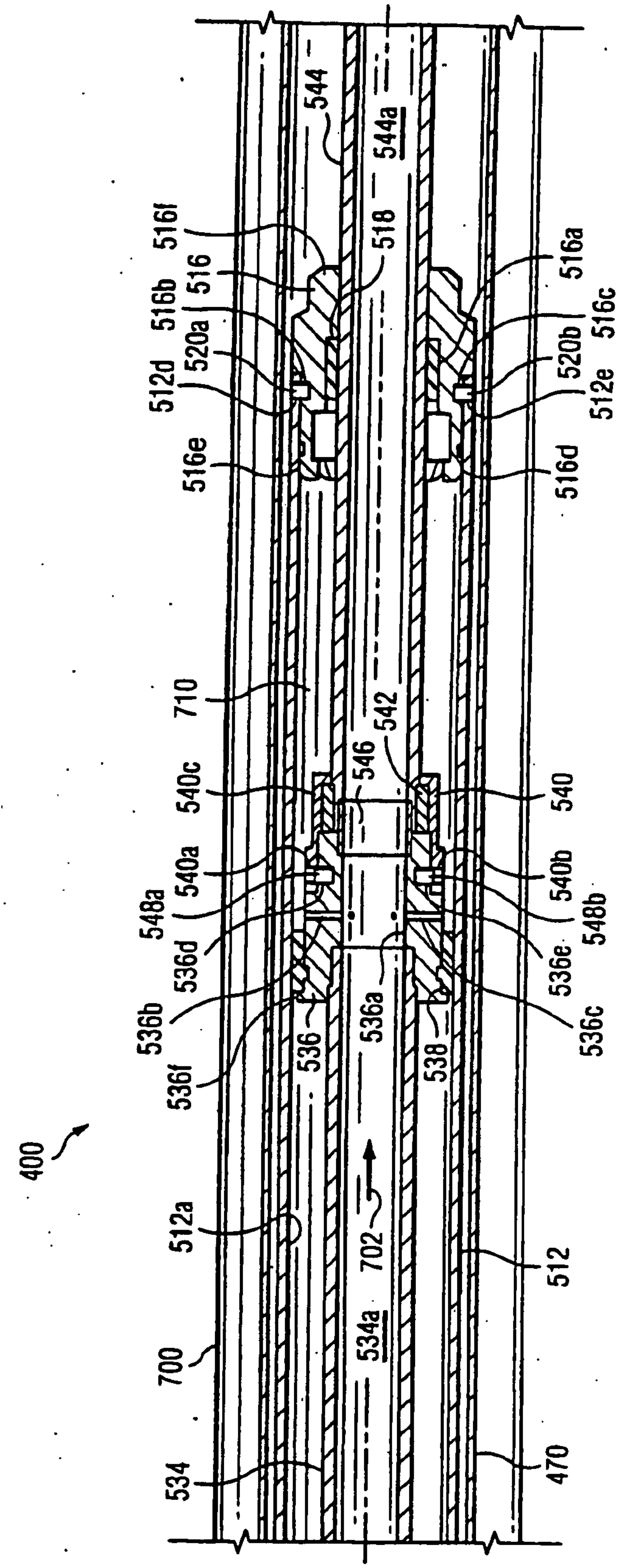
530c
530
532
530a
530d
400
700
502
502a
529a
529
470

Fig. 26g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516d
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540c
540
540a
548a
536d
536b
536f
536
536a
538
540b
548b
536e
536c
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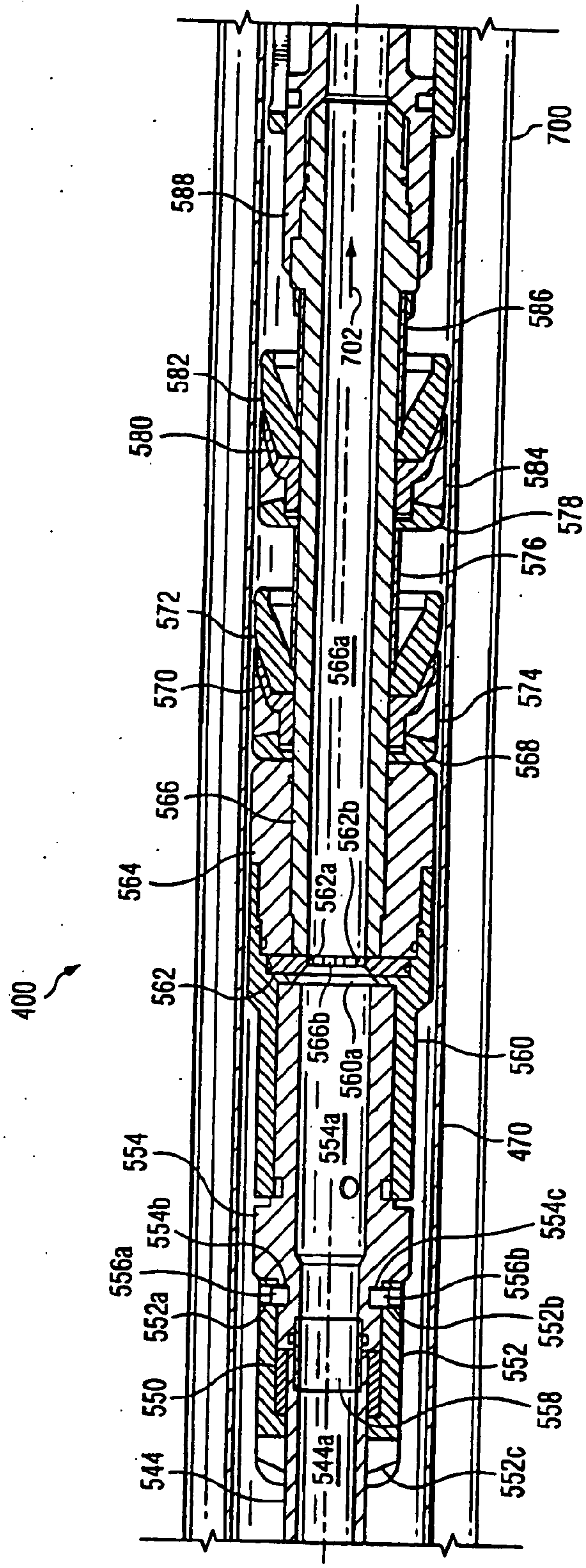
702
534a
700
534
512
470

Fig. 26h



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586
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572
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574
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566
564
562a
562b
562
400
566b
560a
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554c
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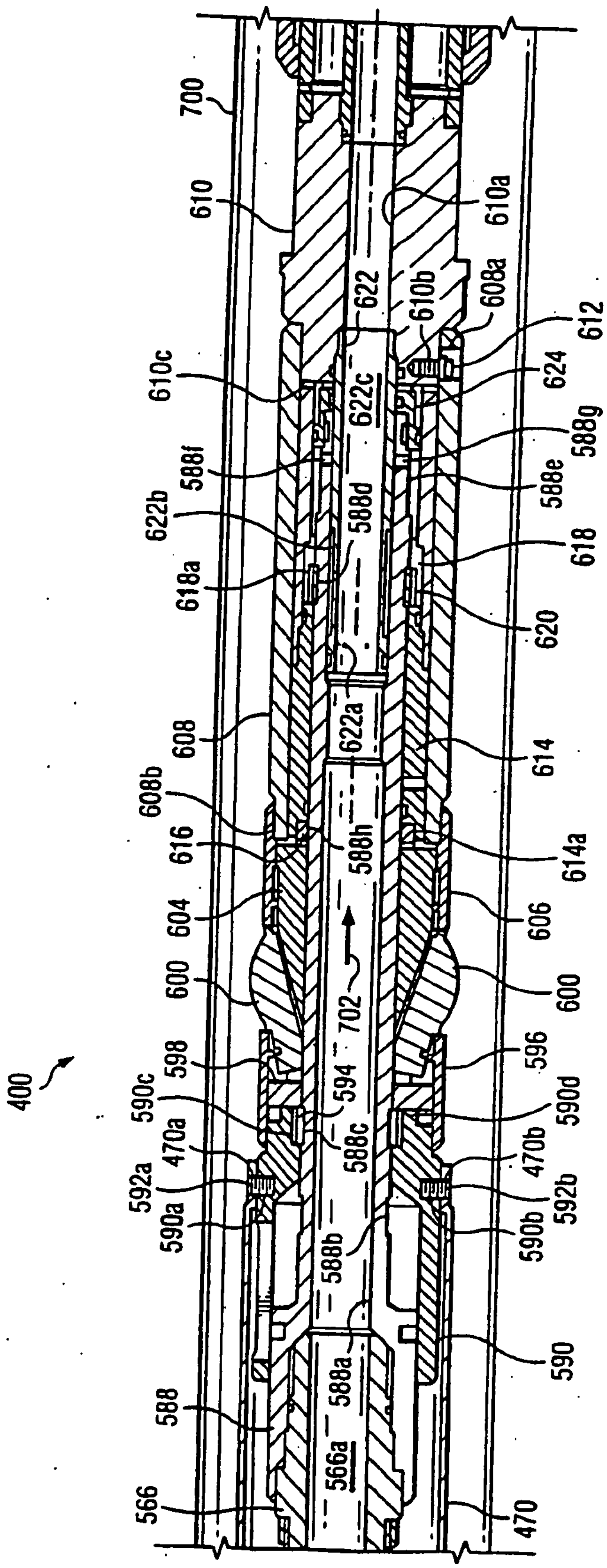
556b
552a
552b
552
550
558
544
544a
552c

Fig. 26i



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618
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622a
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600
702
600
598
594
596
400
590c
590d
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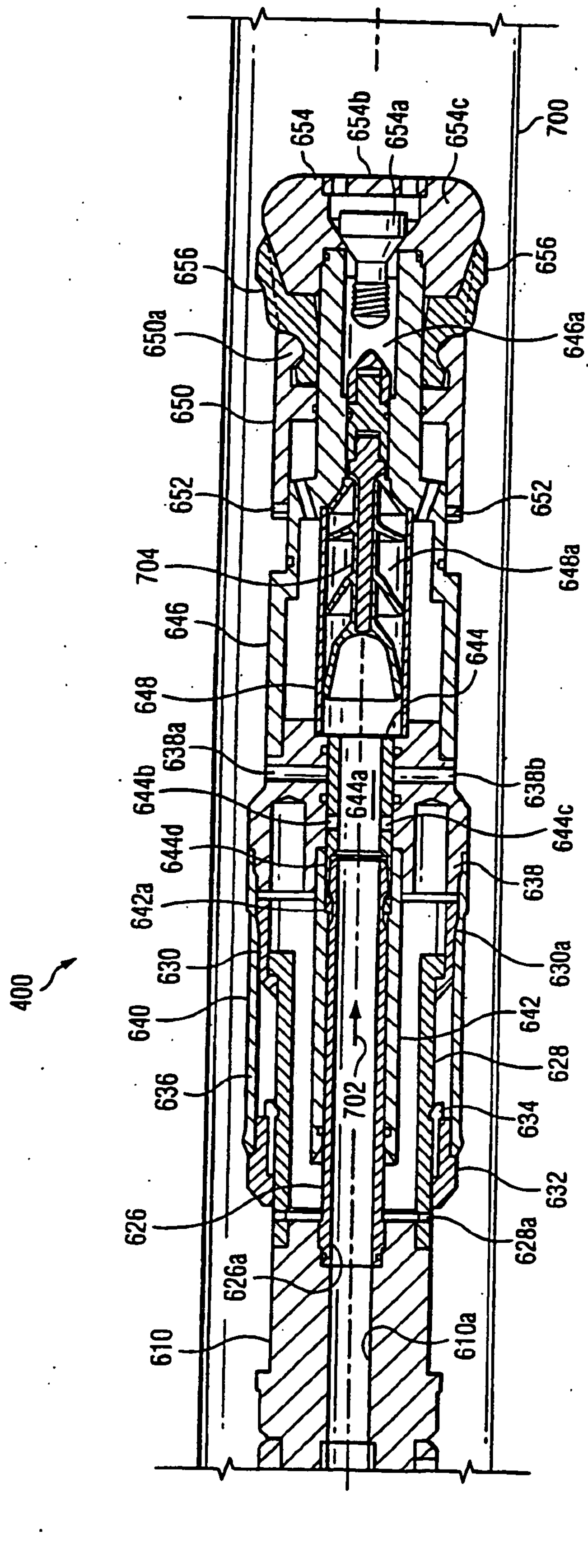
588a
590
588
566a
566
470

Fig. 26j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638b
644b
644a
644c
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632
628a
626a
610
610a

Fig. 26k

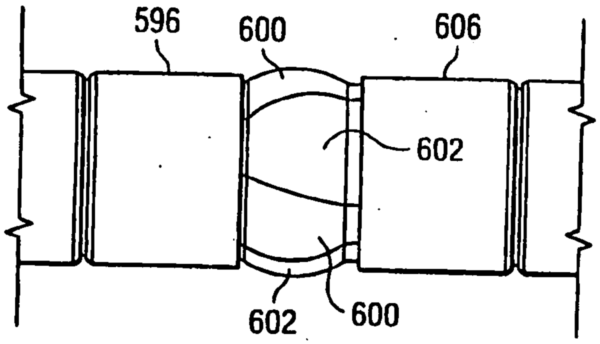


Fig. 27a

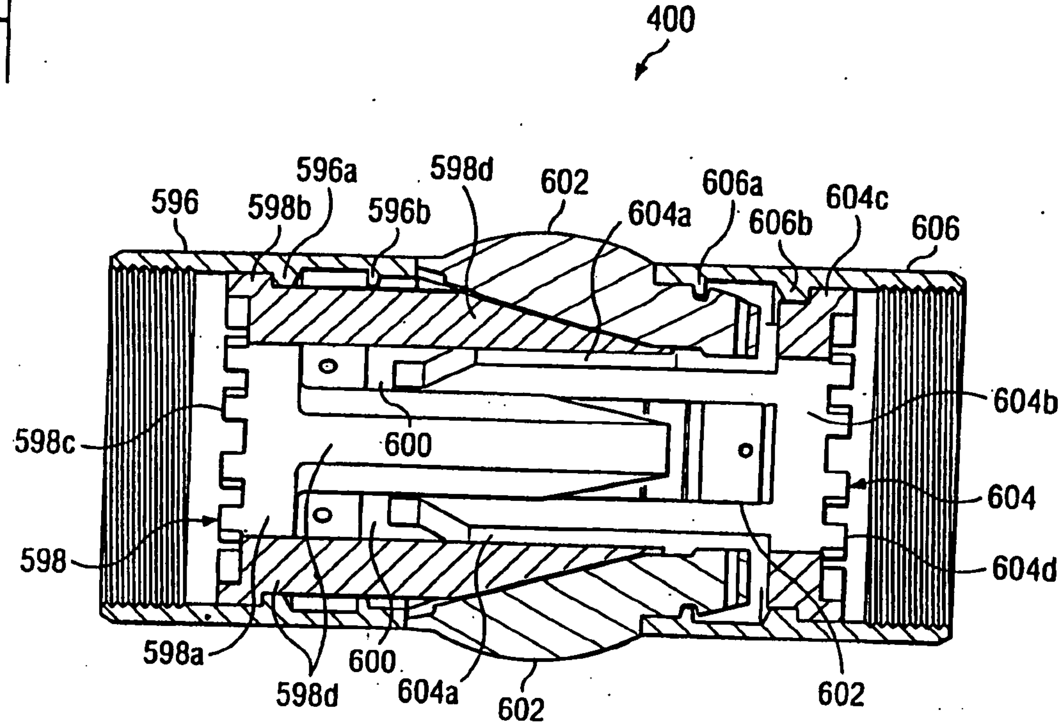
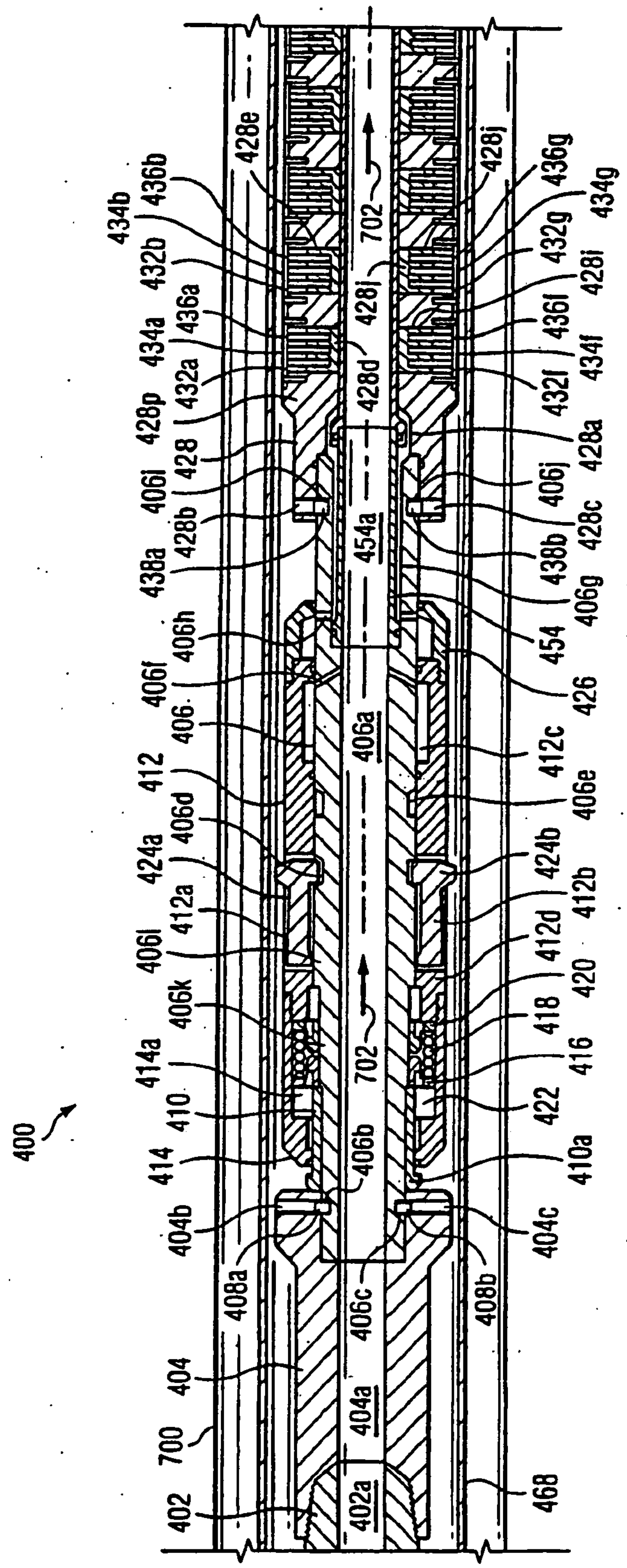


Fig. 27b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432g
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436g
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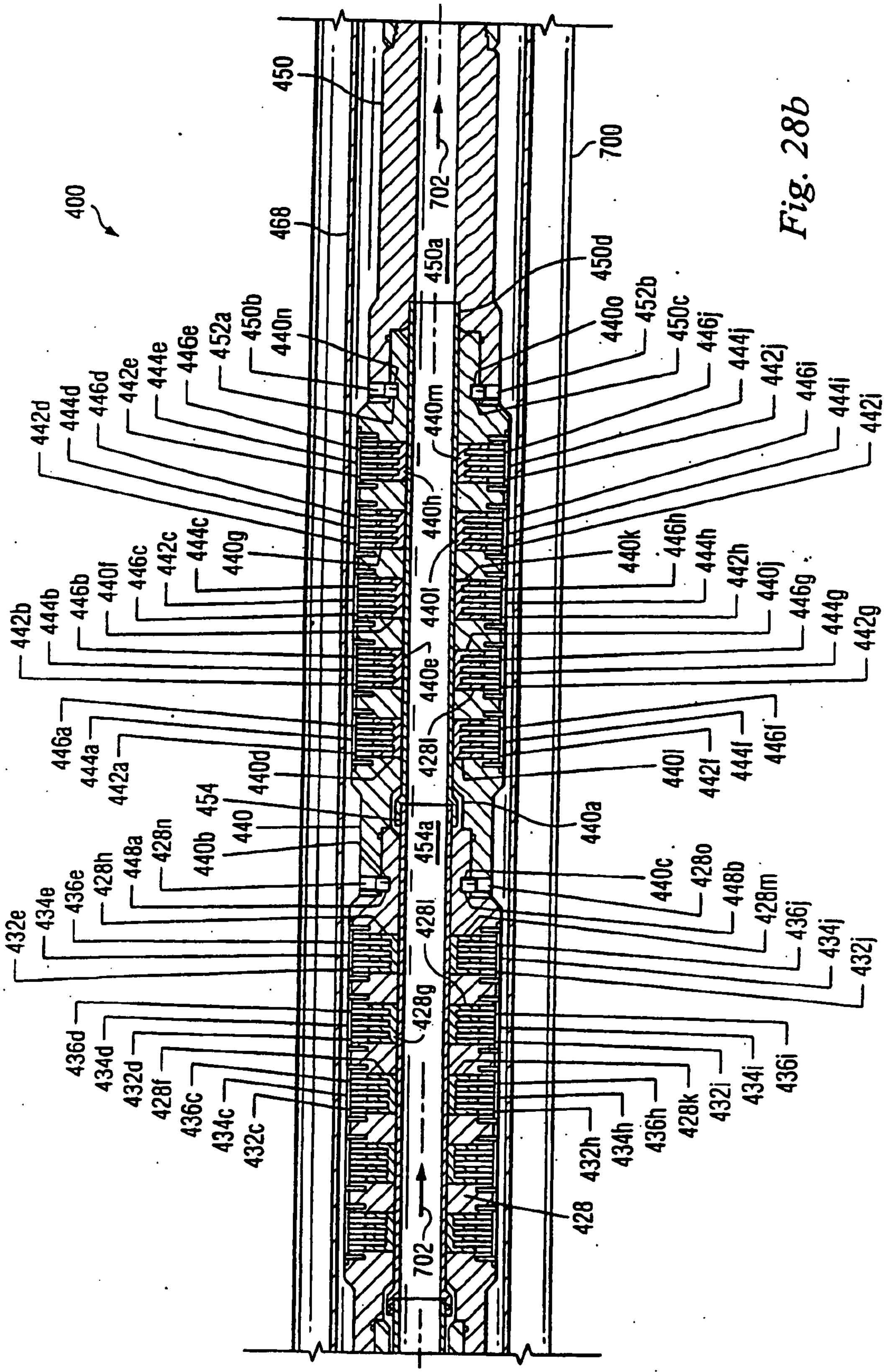
438b
454
454a
468
700
702

Fig. 28a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436h
436i
436j
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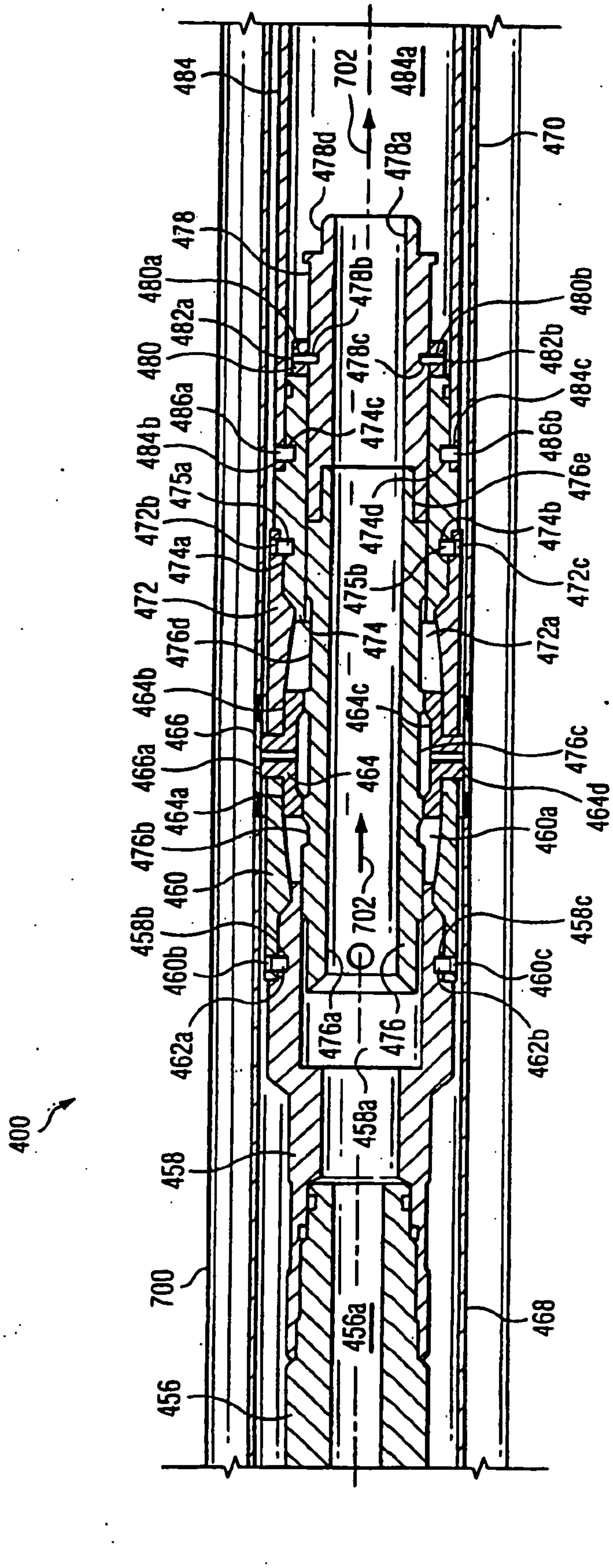
448b

Fig. 28b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486b
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472b
474d
474b
474a
472c
475b
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472a
476d
474
464b
464c
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476c
466a
464
464d
464a
460a
476b
460
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462a
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476
462b
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458a
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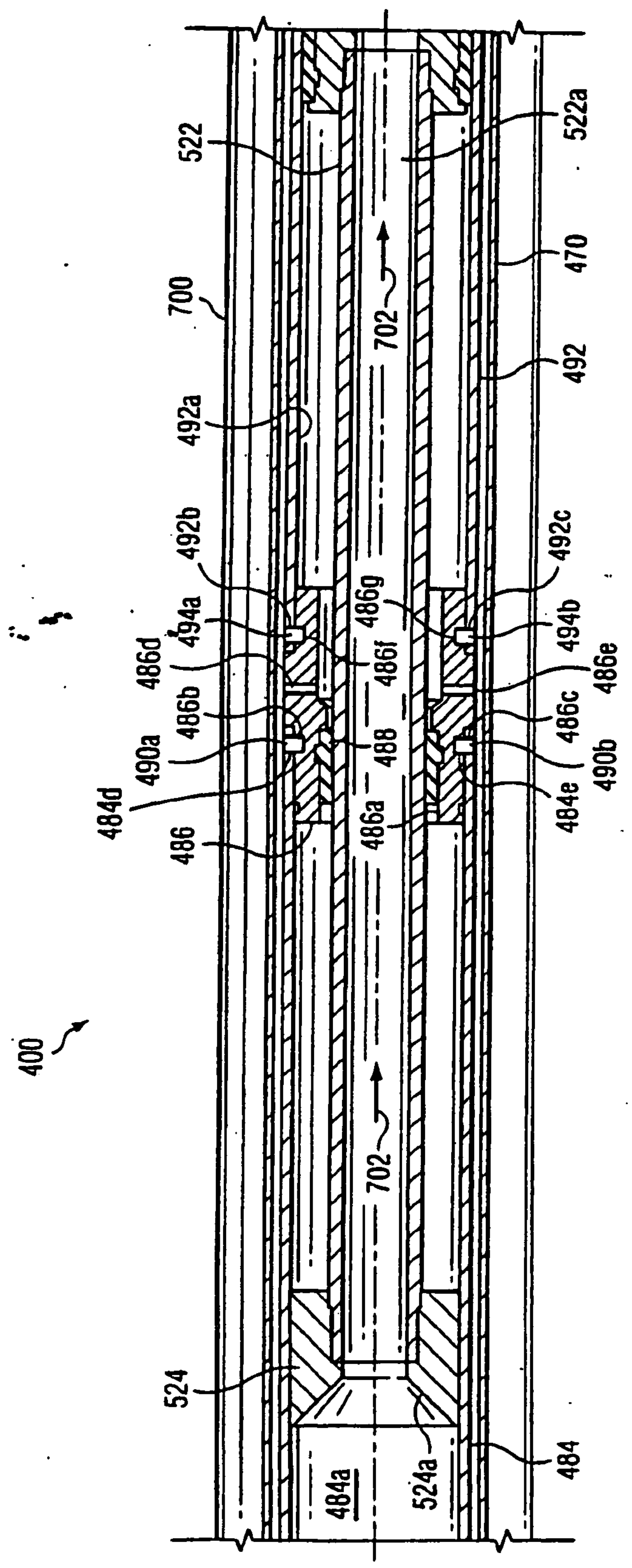
700
456a
468
456

Fig. 28c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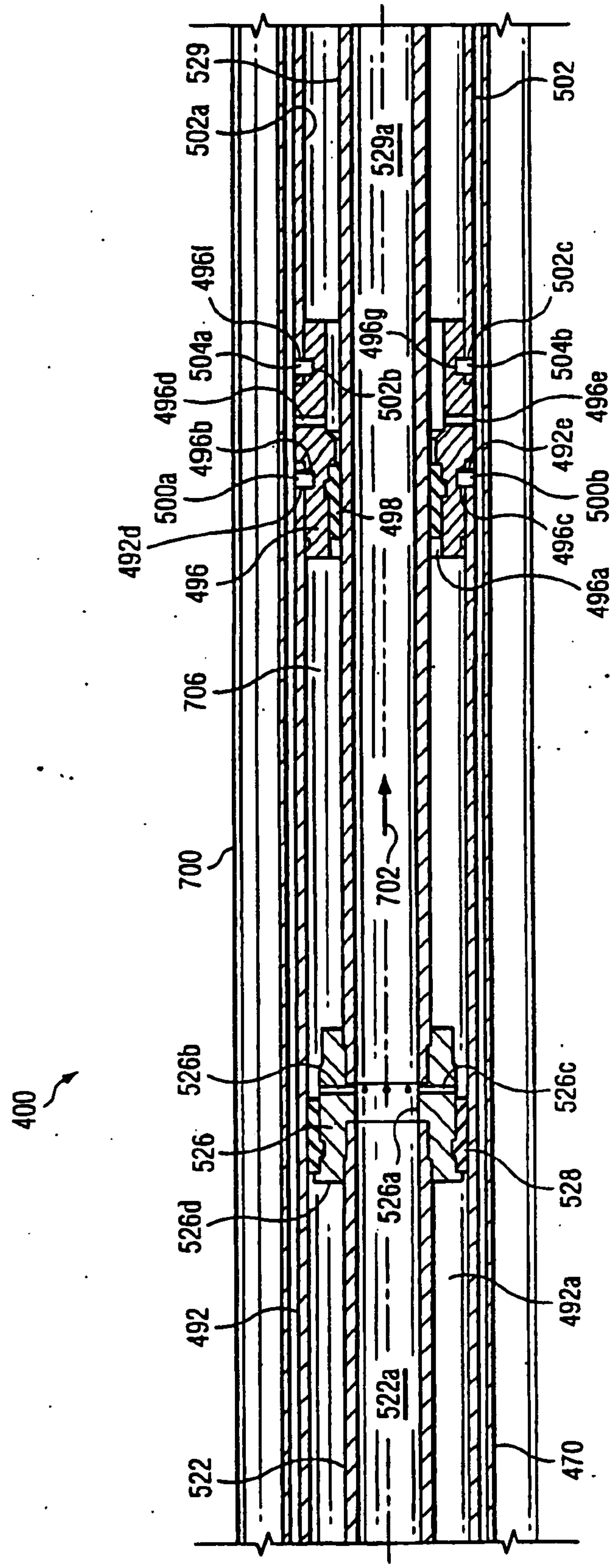
488
490b
484d
484e
486
486a
400
702
524
524a
484a
484

Fig. 28d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500b
492d
498
496c
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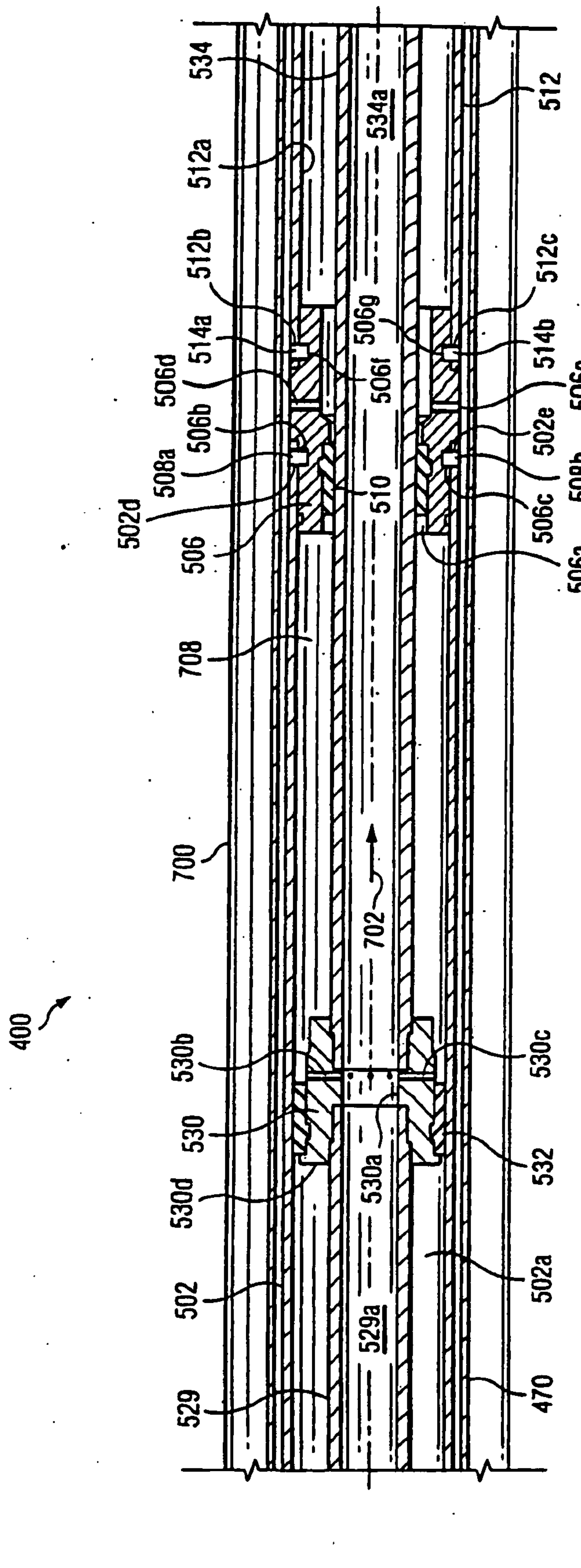
496a
706
700
702
526b
526c
526
526a
528
526d
492
492a
522a
522
470

Fig. 28e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508b
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502d
506c
506
506a
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702
400
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530c
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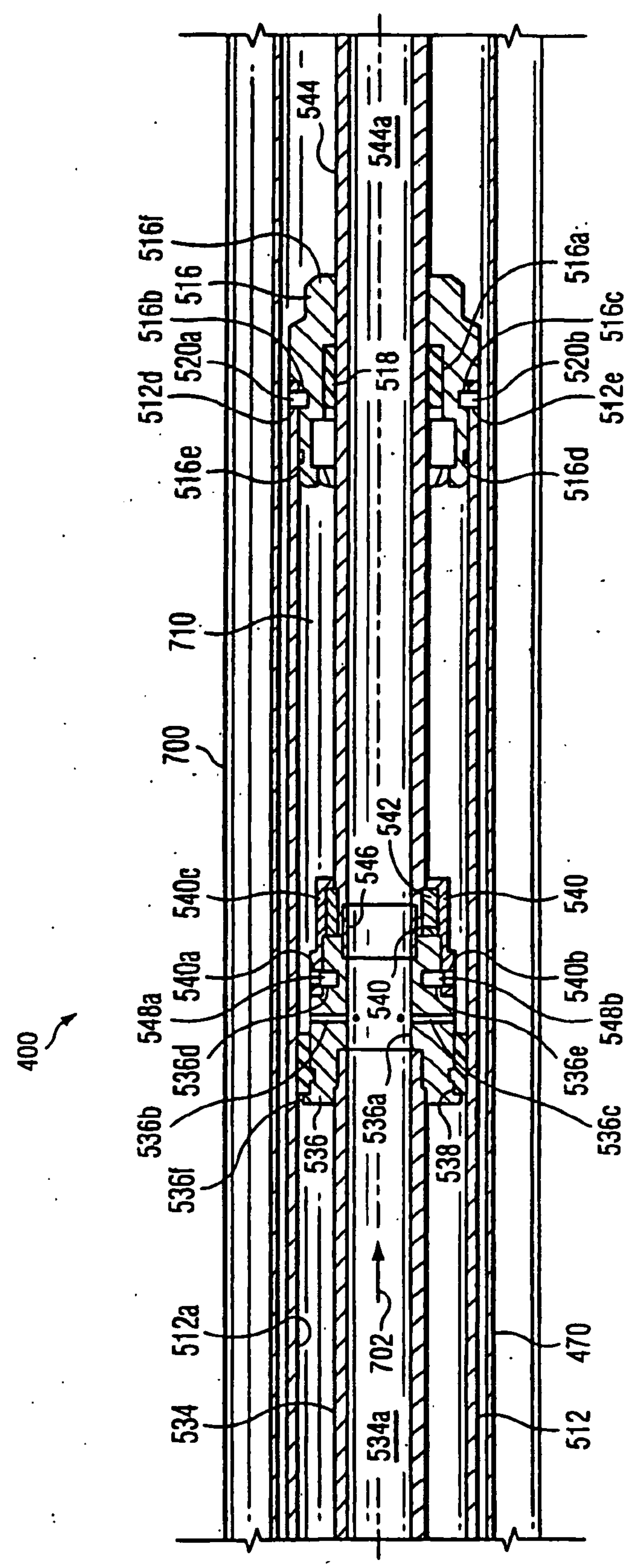
532
530d
530a
502
502a
529
529a
470

Fig. 28f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700
540c
546
542
540
540a
548a
536d
536b
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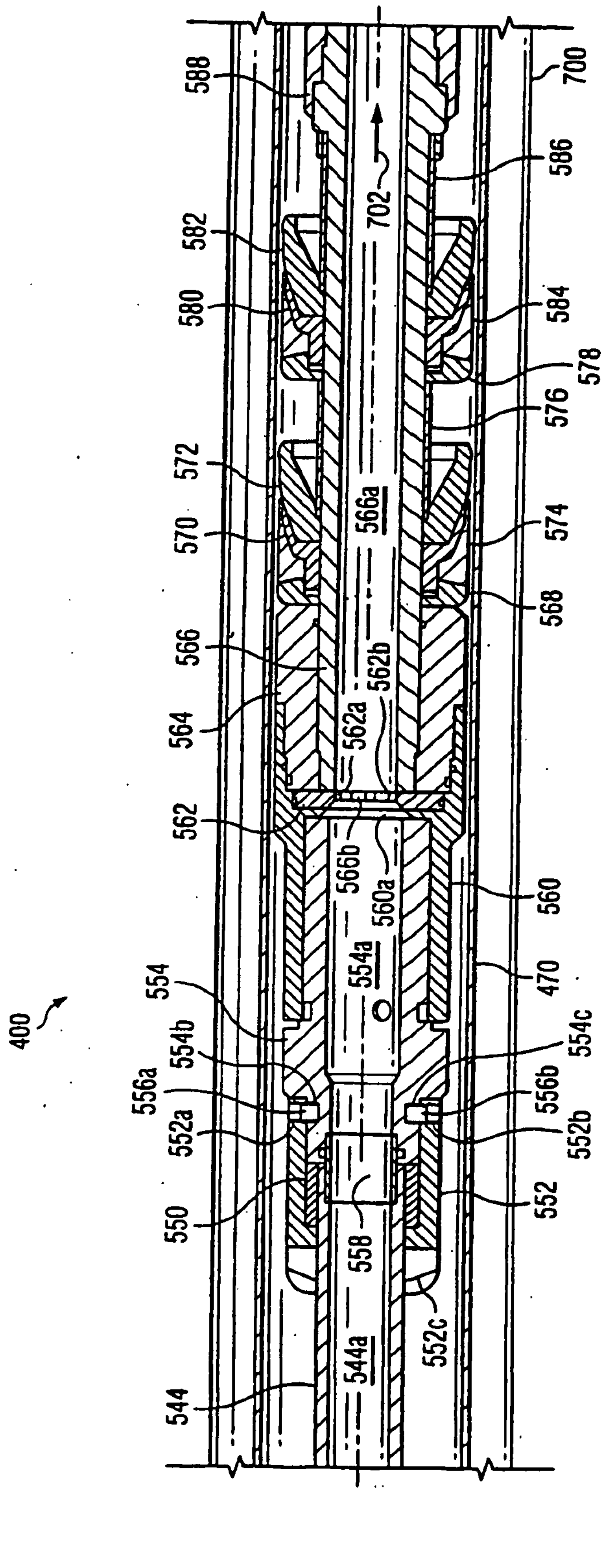
540b
548b
536e
536c
538
512a
702
534a
534
470
512

Fig. 28g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562
566b
560a
560
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556b
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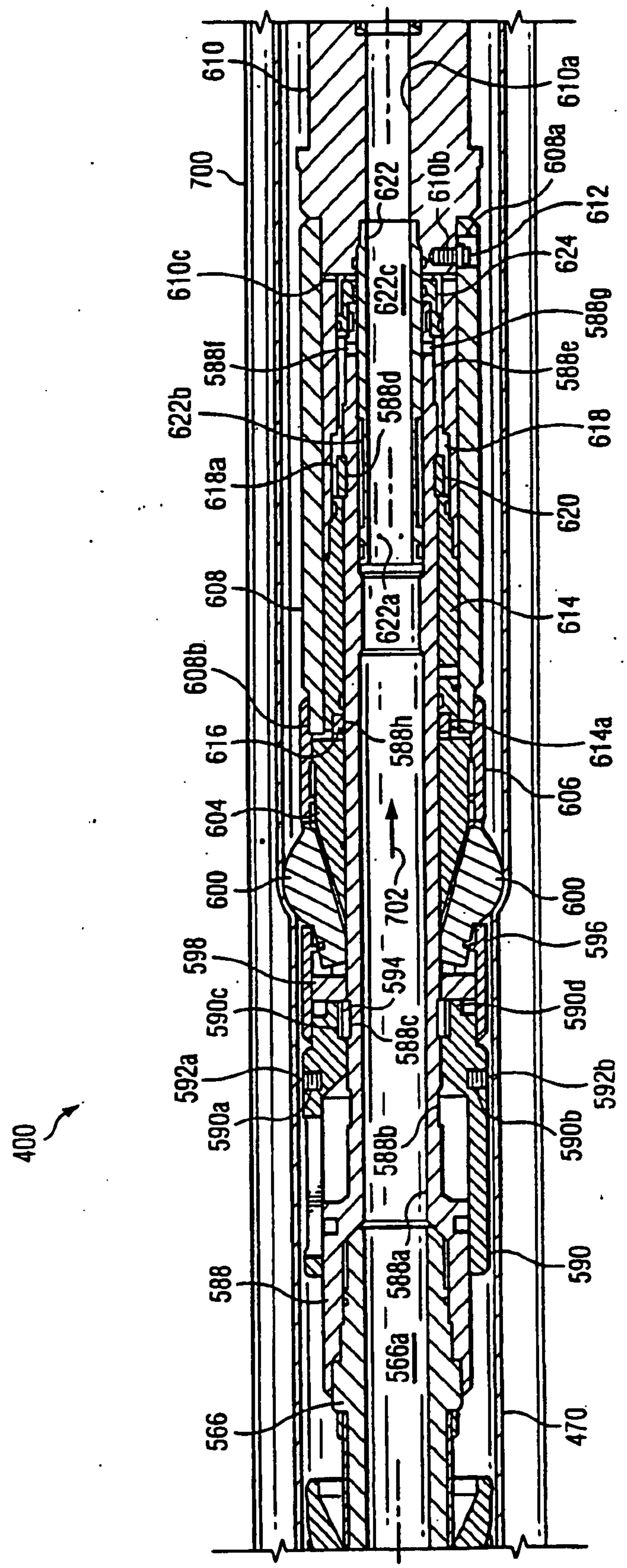
552b
550
552
558
552c
544a
544

Fig. 28h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566
622
610b
622c
588d
622a
588h
702
594
588c
588b
588a
566a
610a
608a
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620
614
614a
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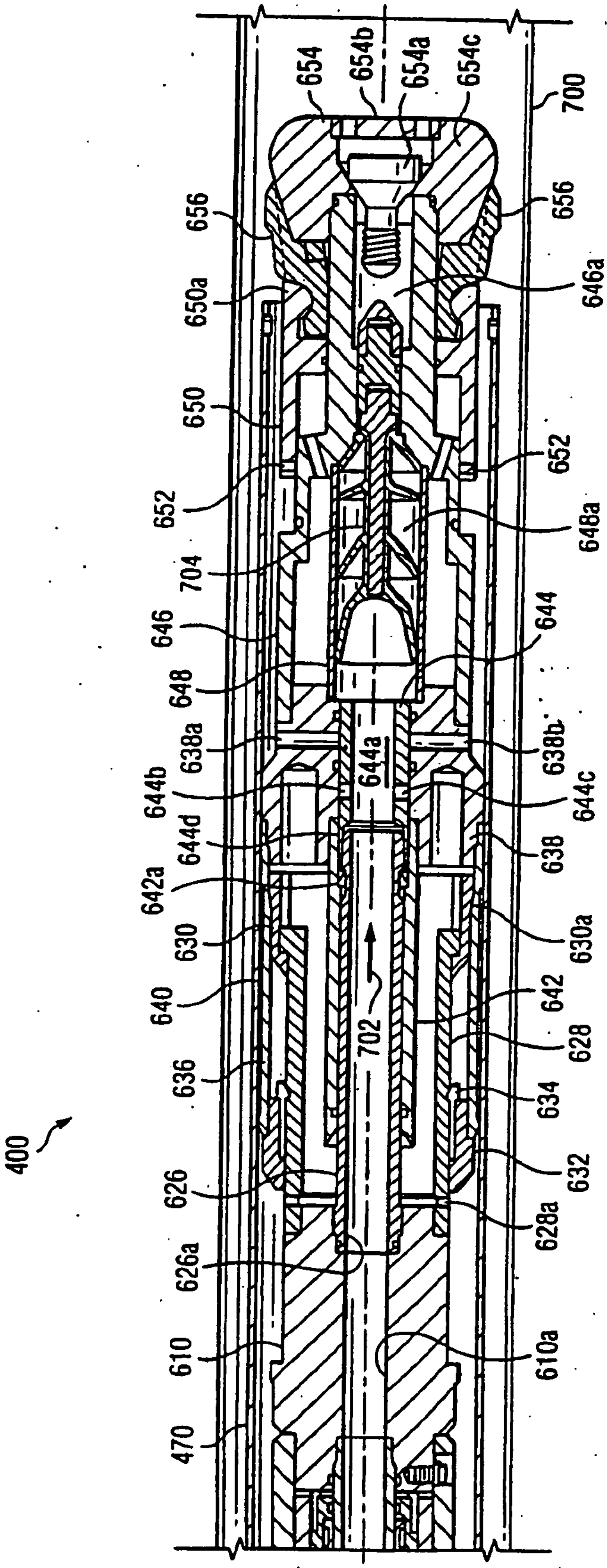
600
596
590d
592b
590b
590
470

Fig. 28i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644b
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644d
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632
628a
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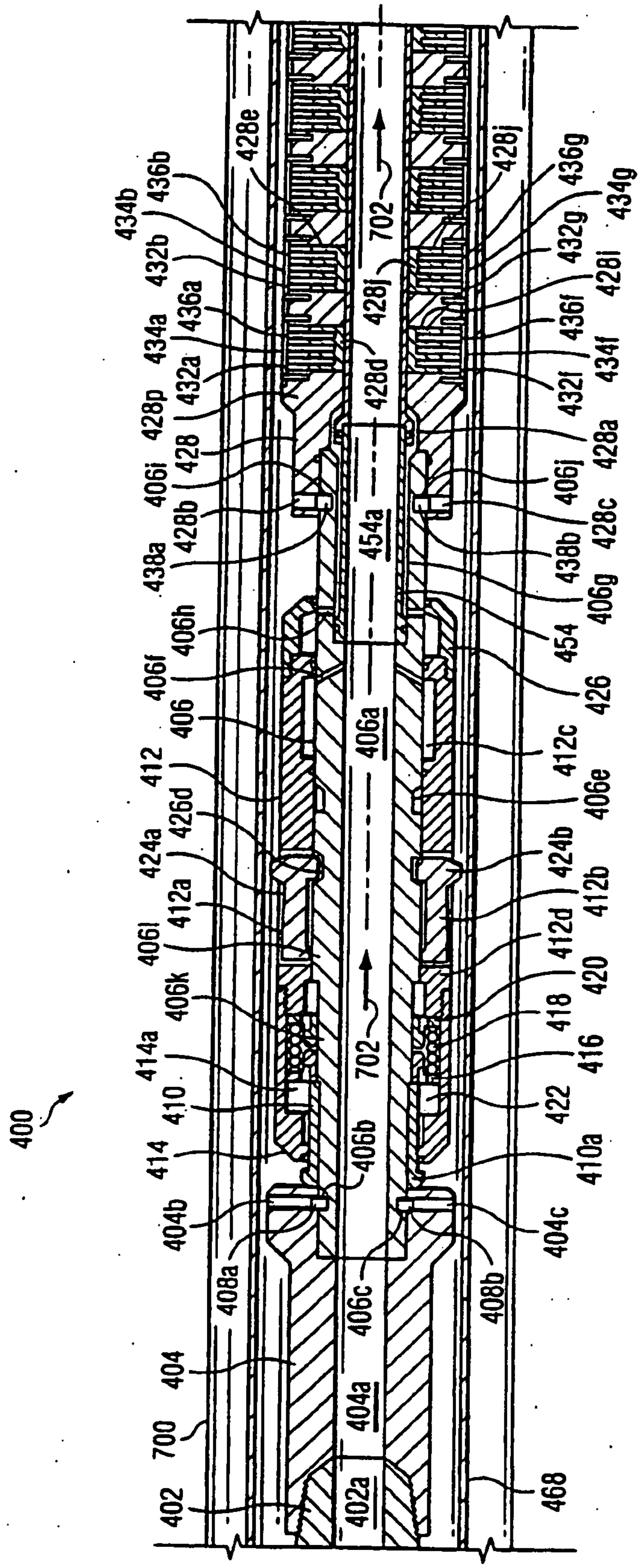
610
610a
470

Fig. 28j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424a
412a
406l
406k
414a
410
414
404b
408a
404
700
402
702
428j
428d
454a
406a
406b
406c
404a
402a
428j
436g
434g
432g
428i
436f
434f
432f
428a
406j
428c
438b
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412d
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418
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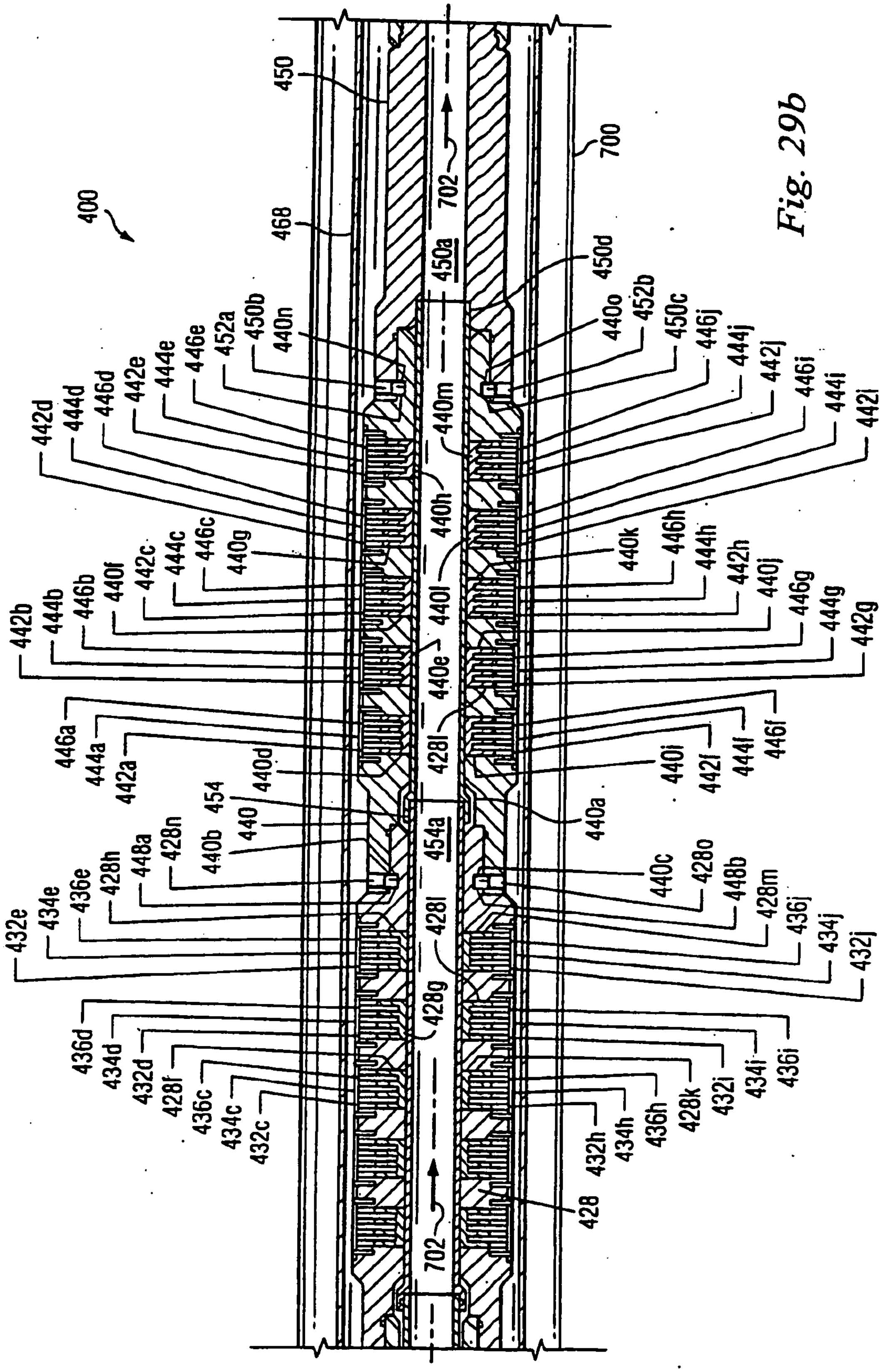
422
410a
404c
408b
468

Fig. 29a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442i
440m
440h
440g
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444c
442c
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444b
442b
440k
446h
444h
442h
440j
446g
444g
442g
440l
440e
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432e
454a
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440c
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448b
428m
436j
434j
432j
428l
428g
436d
434d
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436h
428k
432i
434i
436i
428
702

Fig. 29b

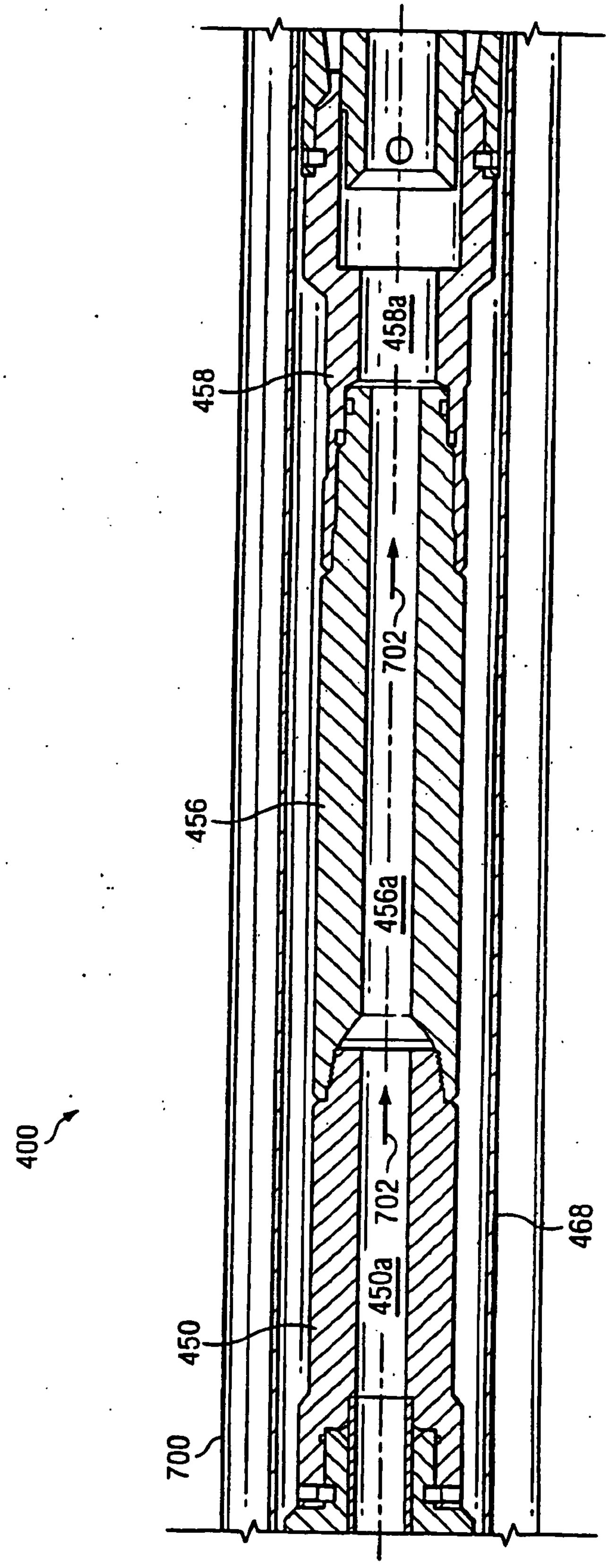
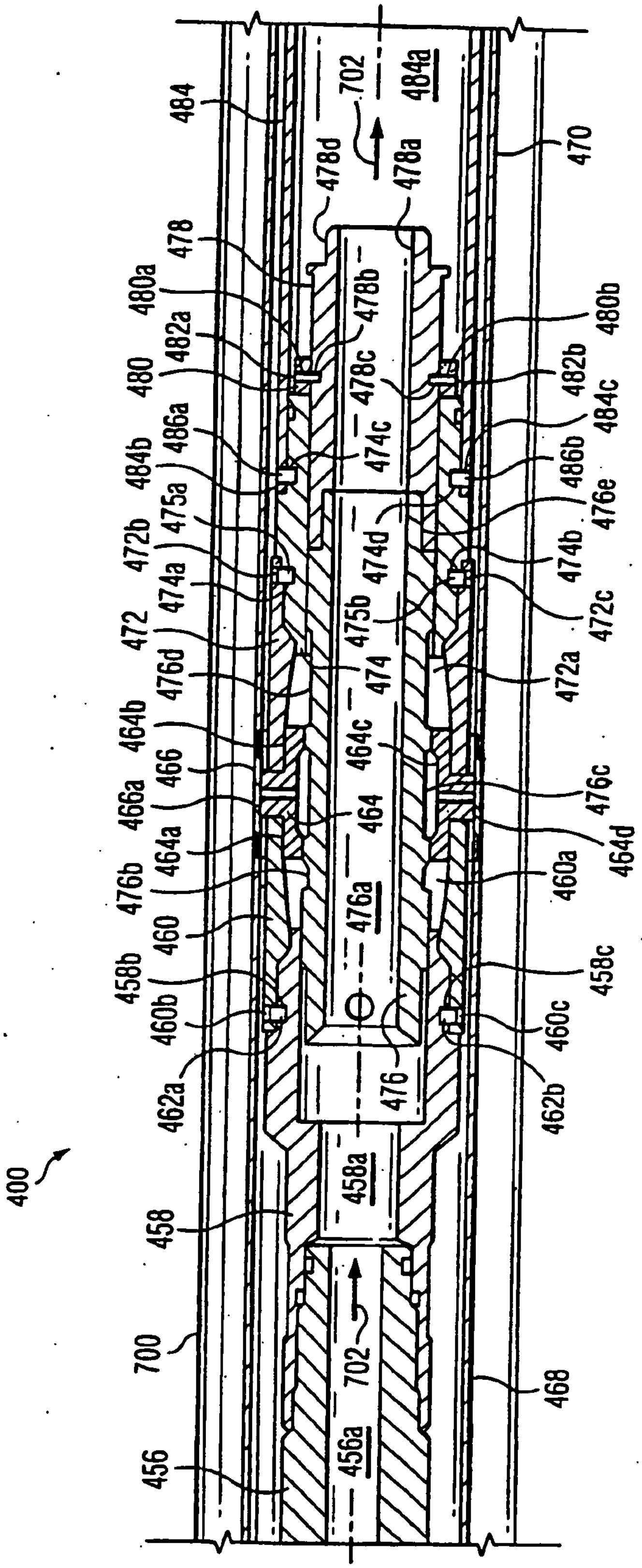


Fig. 29c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464b
464c
464d
466
466a
468
470
472
472a
472b
472c
474
474a
474b
474c
474d
475a
475b
476
476a
476b
476c
476d
476e
478
478a
478b
478c
478d
480
480a
480b
482a
482b
484
484a
484b
484c
486a
486b
700
702

Fig. 29d

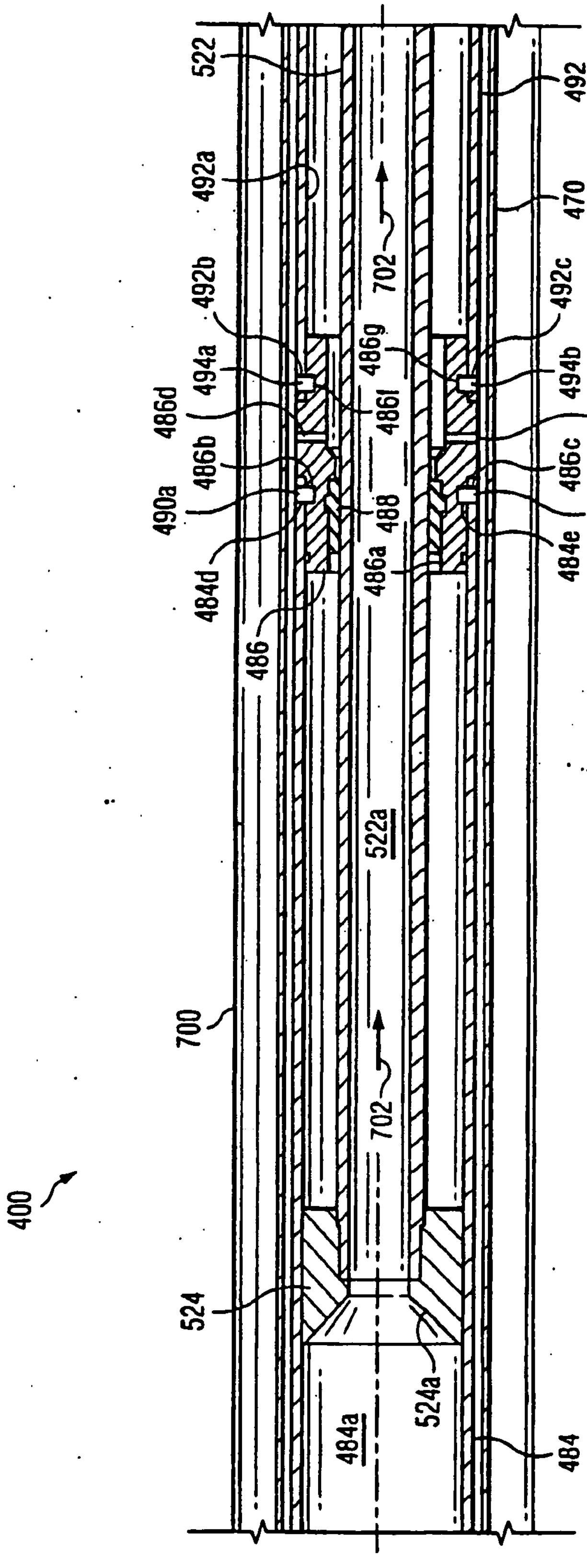

522
492
492a
470
702
492b
492c
486g
494a
494b
486d
486l
486e
486b
486c
490a
488
490b
484d
486a
484e
486
522a
700
702
400
524
524a
484a
484

Fig. 29e

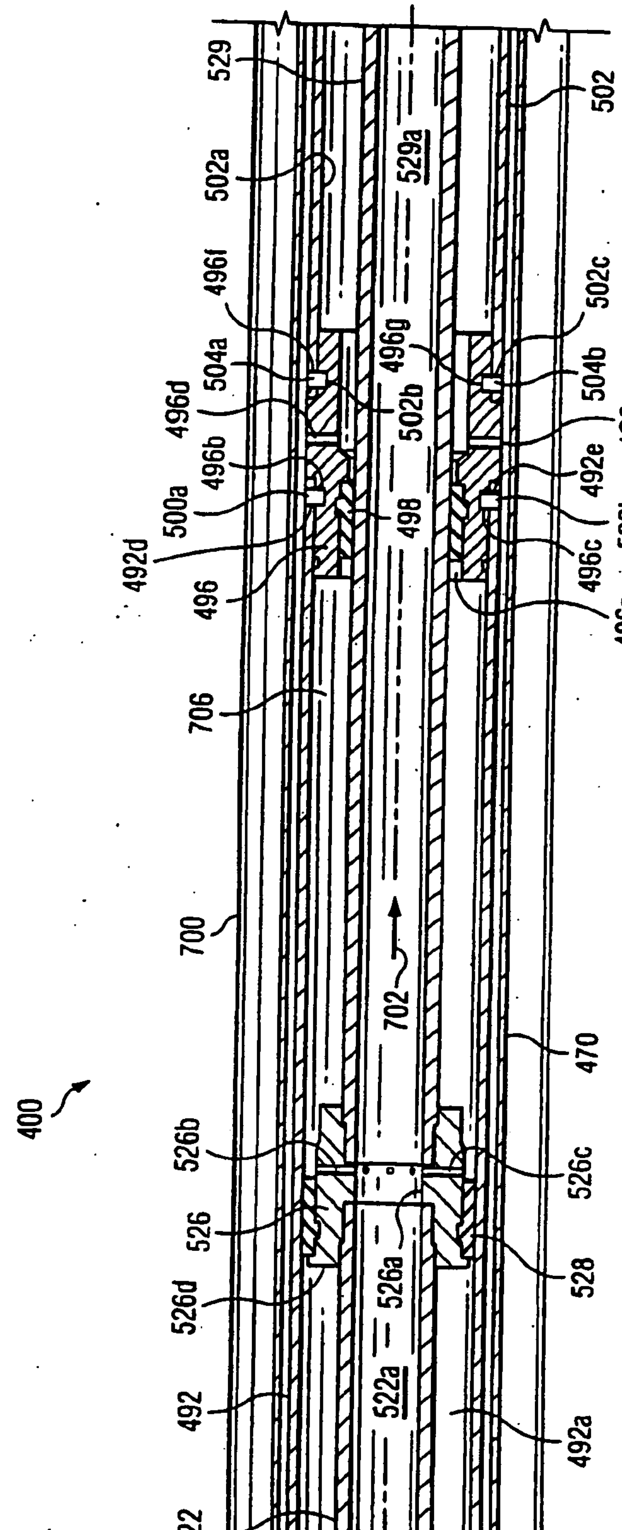
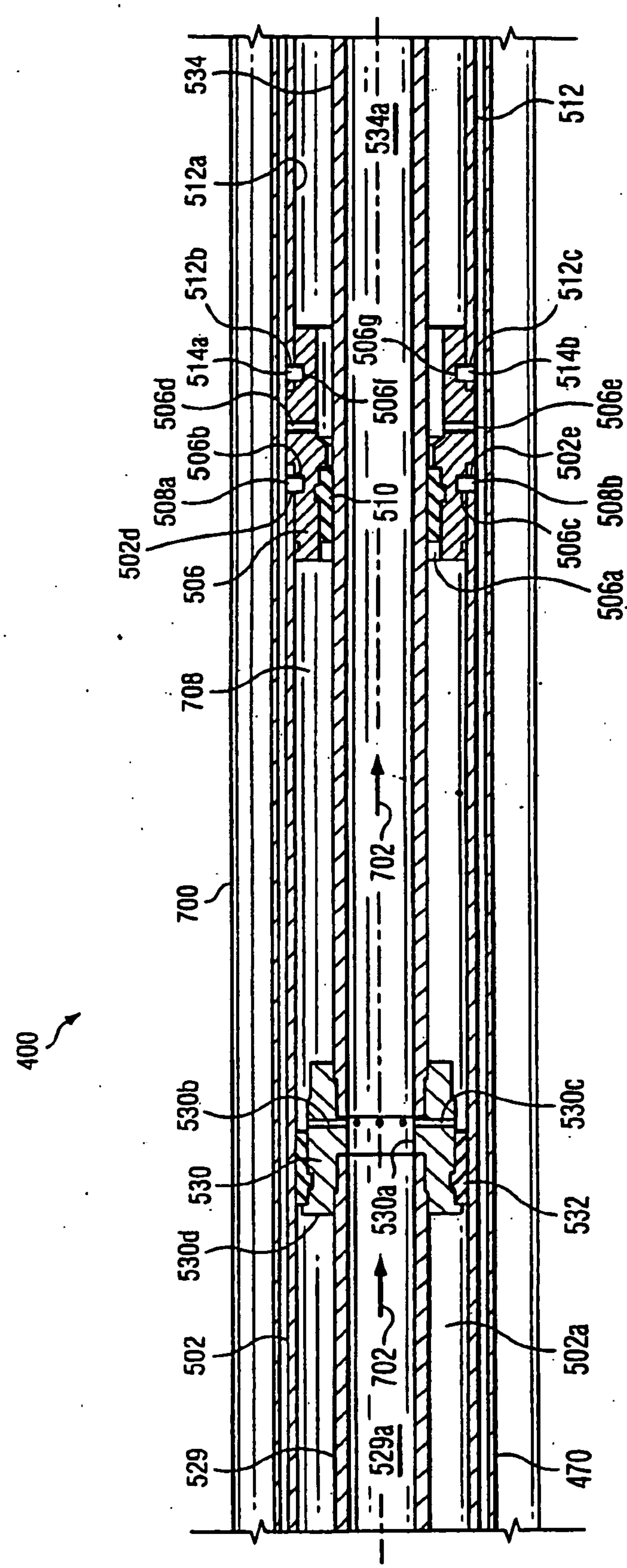
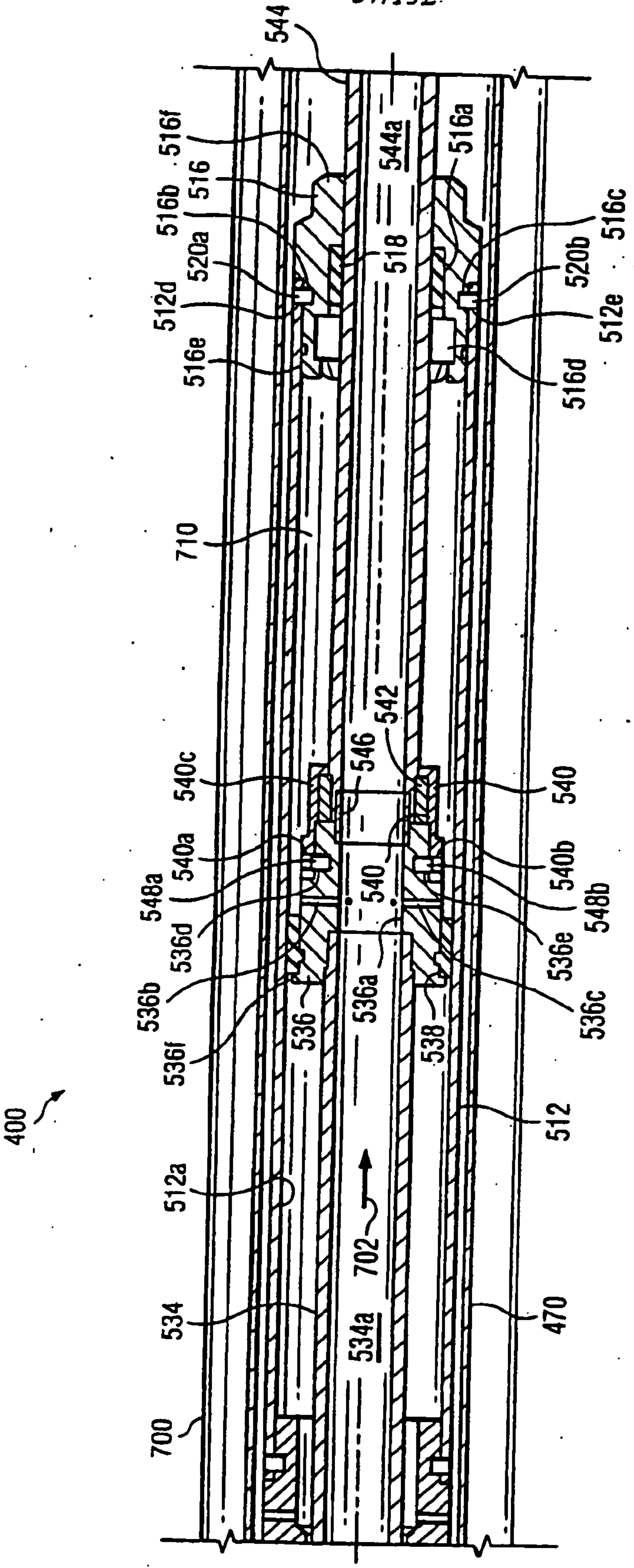

529
502
502a
529a
496f
502c
504a
496g
504b
496d
502b
496e
496b
492e
500a
498
500b
492d
496c
496
496a
706
700
702
470
400
526b
526c
526
526a
528
526d
522a
492
492a
522

Fig. 29f



400
534
534a
512
512a
512b
512c
514a
514b
506g
506f
506d
506e
506b
502e
506a
506c
508a
508b
510
502d
506
708
702
700
530b
530c
530
530a
532
530d
502
502a
529
529a
470

Fig. 29g



544
544a
516f
516
516a
516b
520a
518
516c
512d
520b
512e
516e
516d
710
542
546
540c
540
540a
540b
548a
540
536d
548b
536e
536b
536a
536c
536f
536
538
400
512a
512
702
534
470
534a
700

Fig. 29h

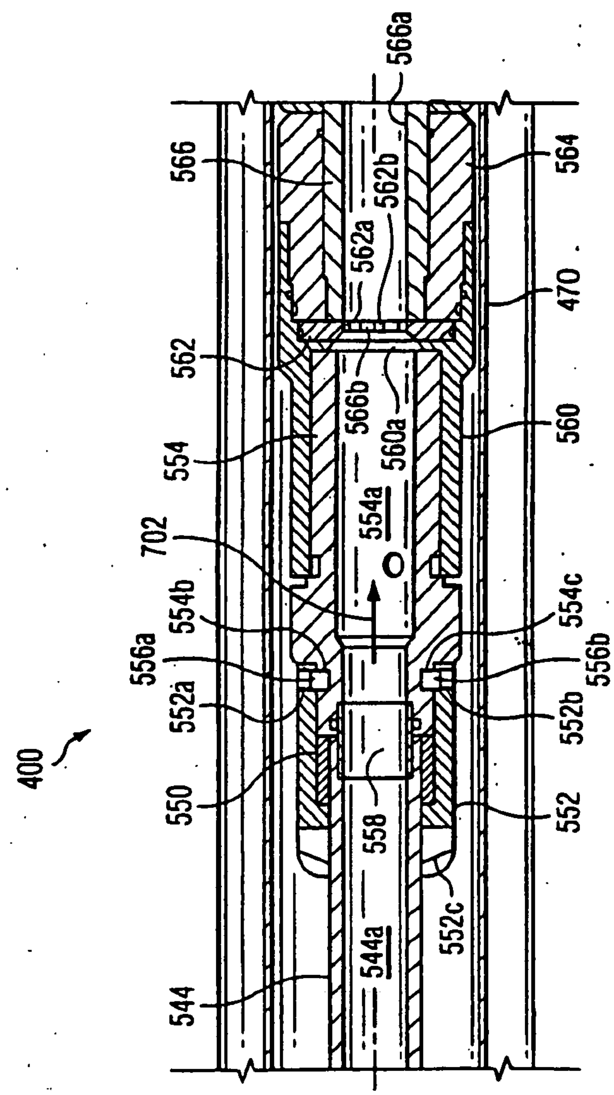

400
566a
566
564
562b
562a
470
562
566b
560a
554
560
554a
702
554b
554c
556a
556b
552a
552b
550
558
552
552c
544a
544

Fig. 29i

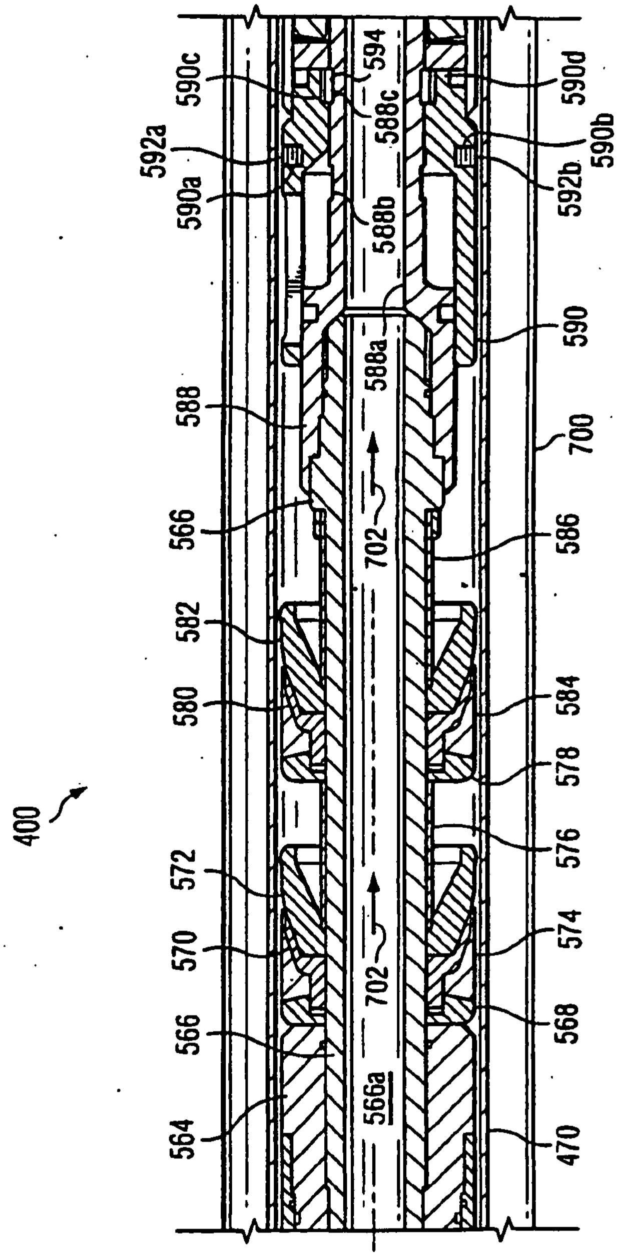

400
590c
592a
590a
594
588c
588b
588a
588
566
702
582
580
572
570
566
566a
564
590d
590b
592b
590
700
586
584
578
576
574
568
470

Fig. 29j

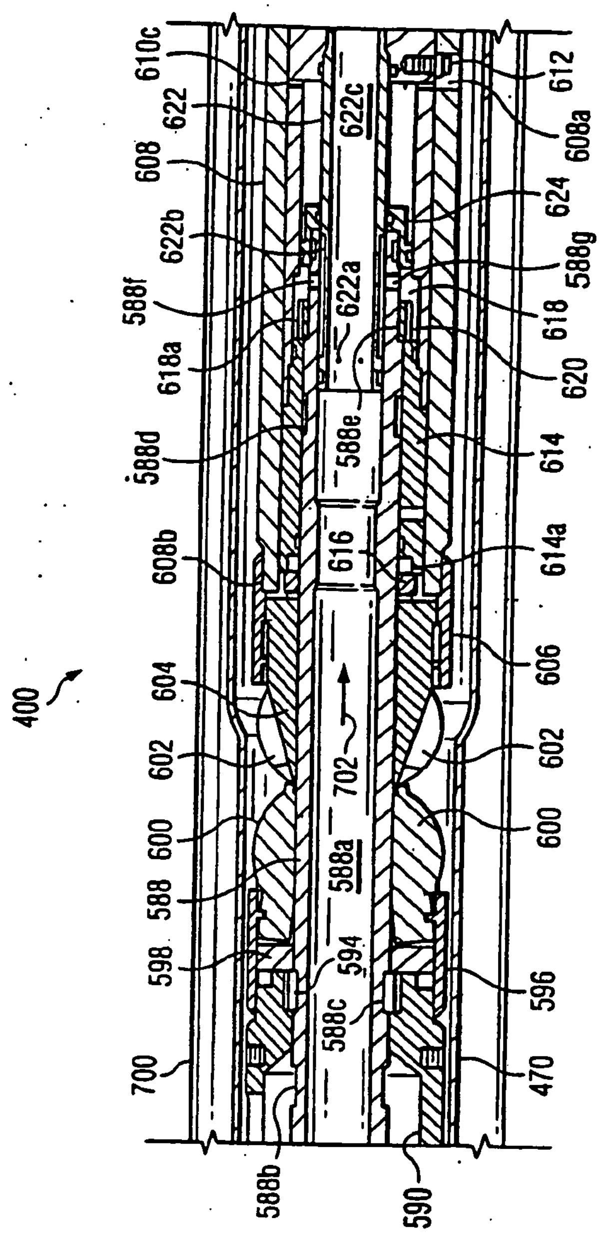

400
610c
622
608
622b
588f
618a
588d
608b
604
602
600
588
598
700
588b
622c
622a
588e
616
702
588a
594
588c
590
612
608a
624
588g
618
620
614
614a
606
602
600
596
470

Fig. 29k

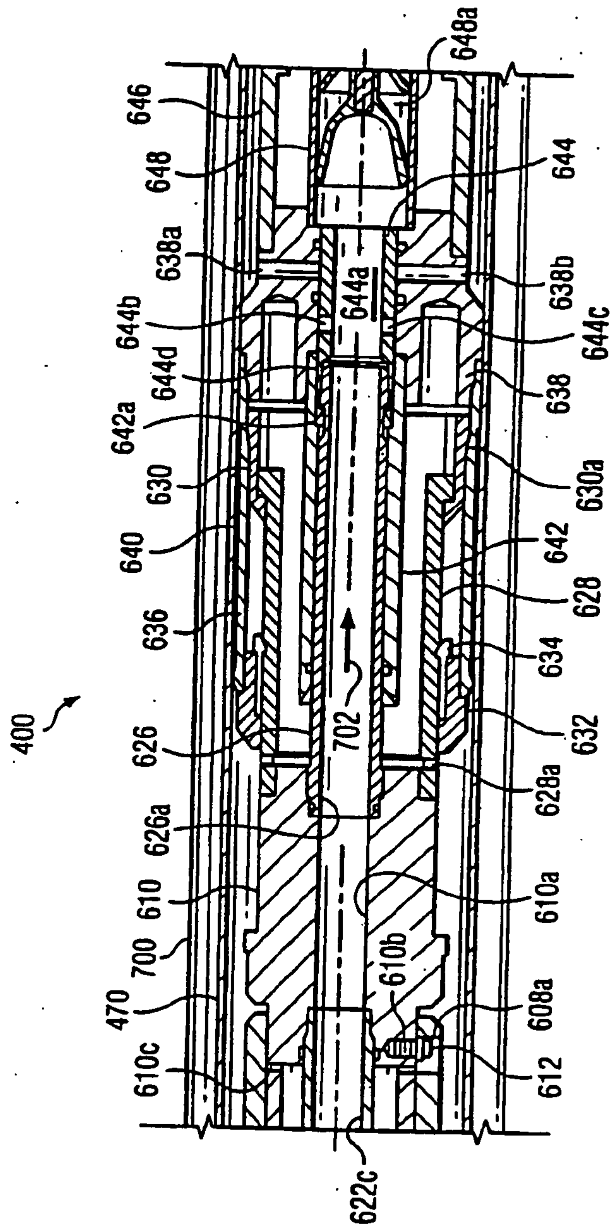

400
646
648
648a
644
638a
638b
644b
644a
644c
644d
638
642a
630
630a
640
642
628
636
634
702
626
632
628a
626a
610
610a
700
610b
470
608a
610c
612
622c

Fig. 29I

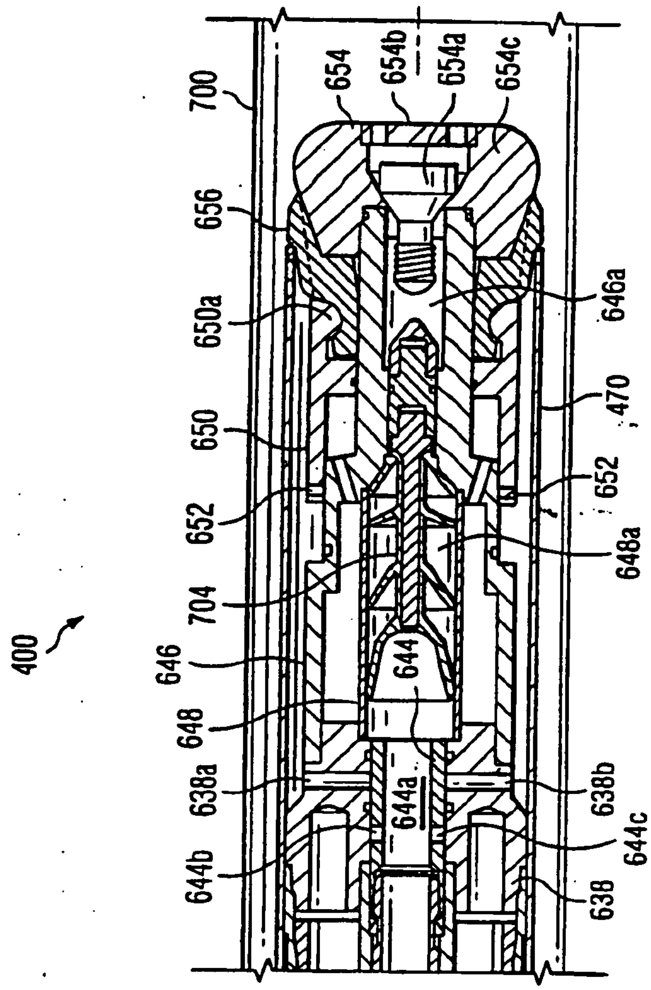

400
700
654
654b
654a
654c
656
650a
646a
650
470
652
652
704
648a
646
644
648
638a
638b
644a
644b
644c
638

Fig. 29m

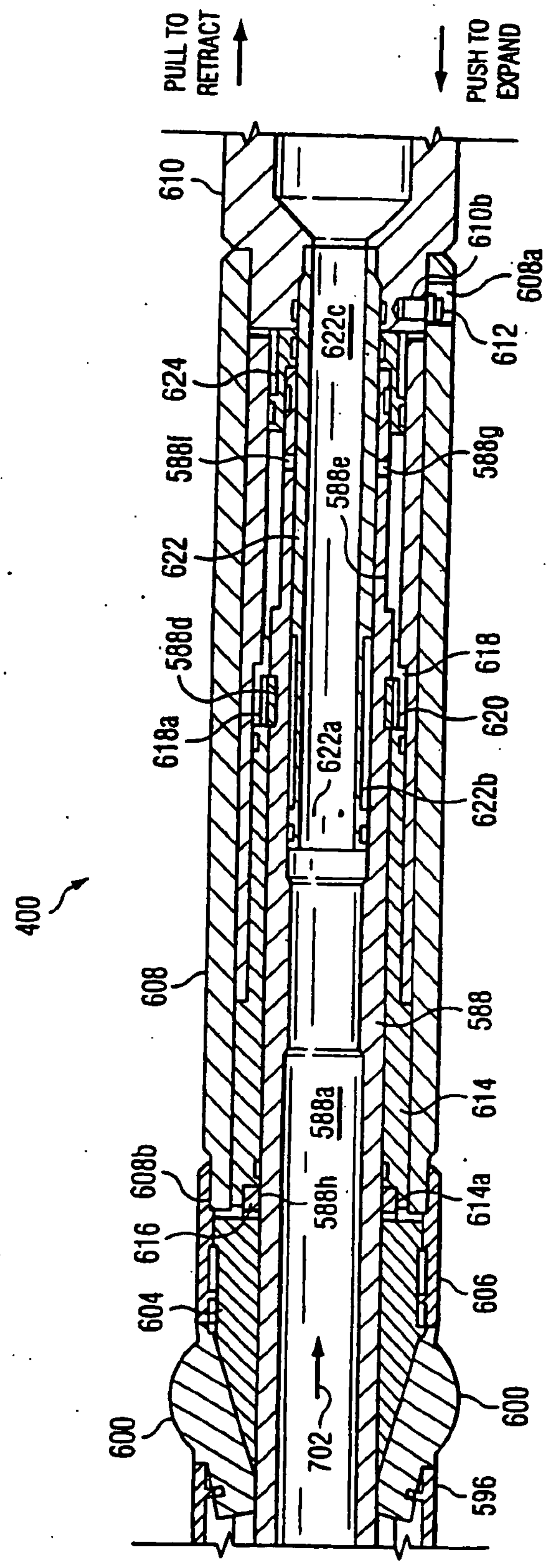

PULL TO RETRACT
PUSH TO EXPAND
610
610b
608a
612
624
622c
588f
588e
588g
622
588d
618
618a
620
622a
622b
400
608
588
588a
614
608b
588h
614a
616
604
606
600
600
702
596

Fig. 30a

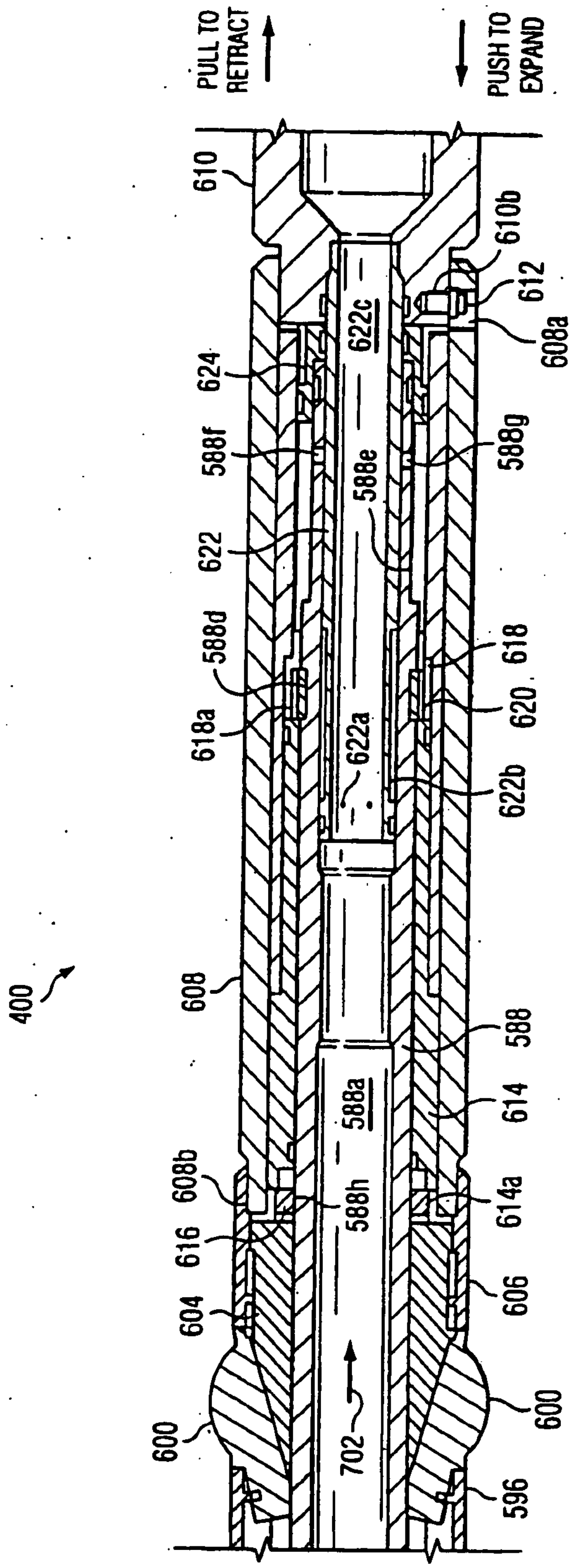

PULL TO RETRACT
PUSH TO EXPAND
400
610
610b
612
608a
624
622c
588f
588g
588e
622
588d
618
618a
620
622a
622b
608
588
588a
614
608b
588h
614a
616
606
604
600
600
702
596

Fig. 30b

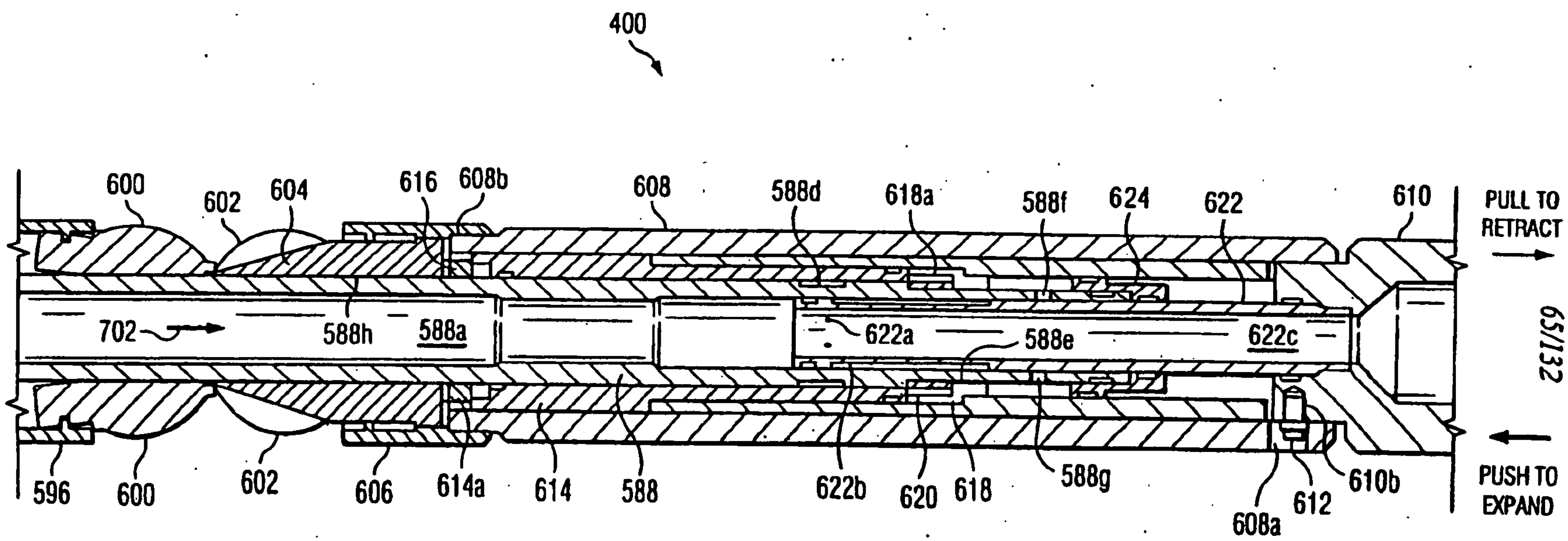
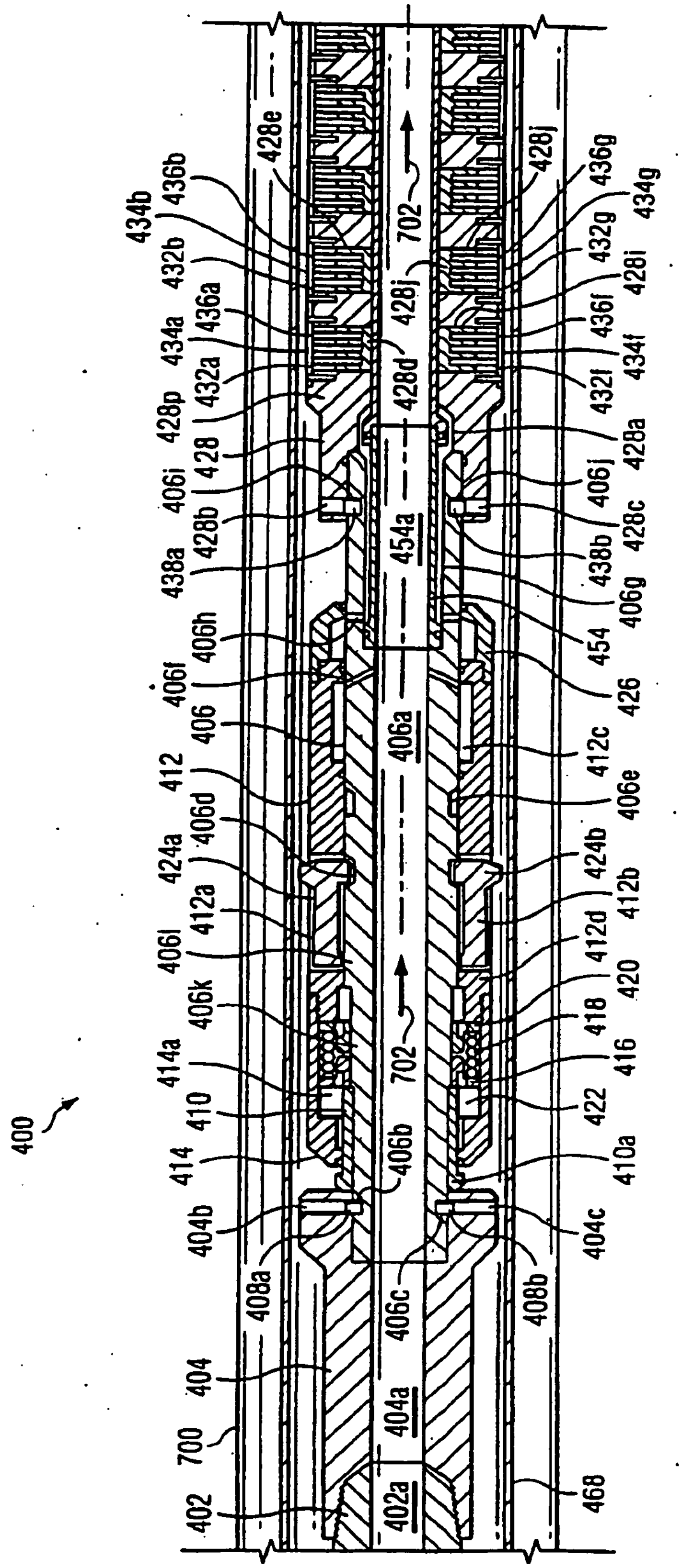

400
600
602
604
616
608b
608
588d
618a
588f
624
622
610
PULL TO RETRACT
702
588h
588a
622a
588e
622c
PUSH TO EXPAND
596
600
602
606
614a
614
588
622b
620
618
588g
608a
612
610b

Fig. 30c



400
402
700
404
408a
404b
414
410
414a
406k
406l
412a
424a
406d
412
406
406f
406h
438a
428b
406i
428
428p
432a
434a
436a
432b
434b
436b
428e
402a
404a
406c
406b
702
406a
454a
428d
428i
428j
468
408b
404c
410a
422
416
418
420
412d
412b
424b
406e
412c
426
454
406g
438b
428c
406j
428a
432f
434f
436f
428i
432g
434g
436g
428j

Fig. 31a

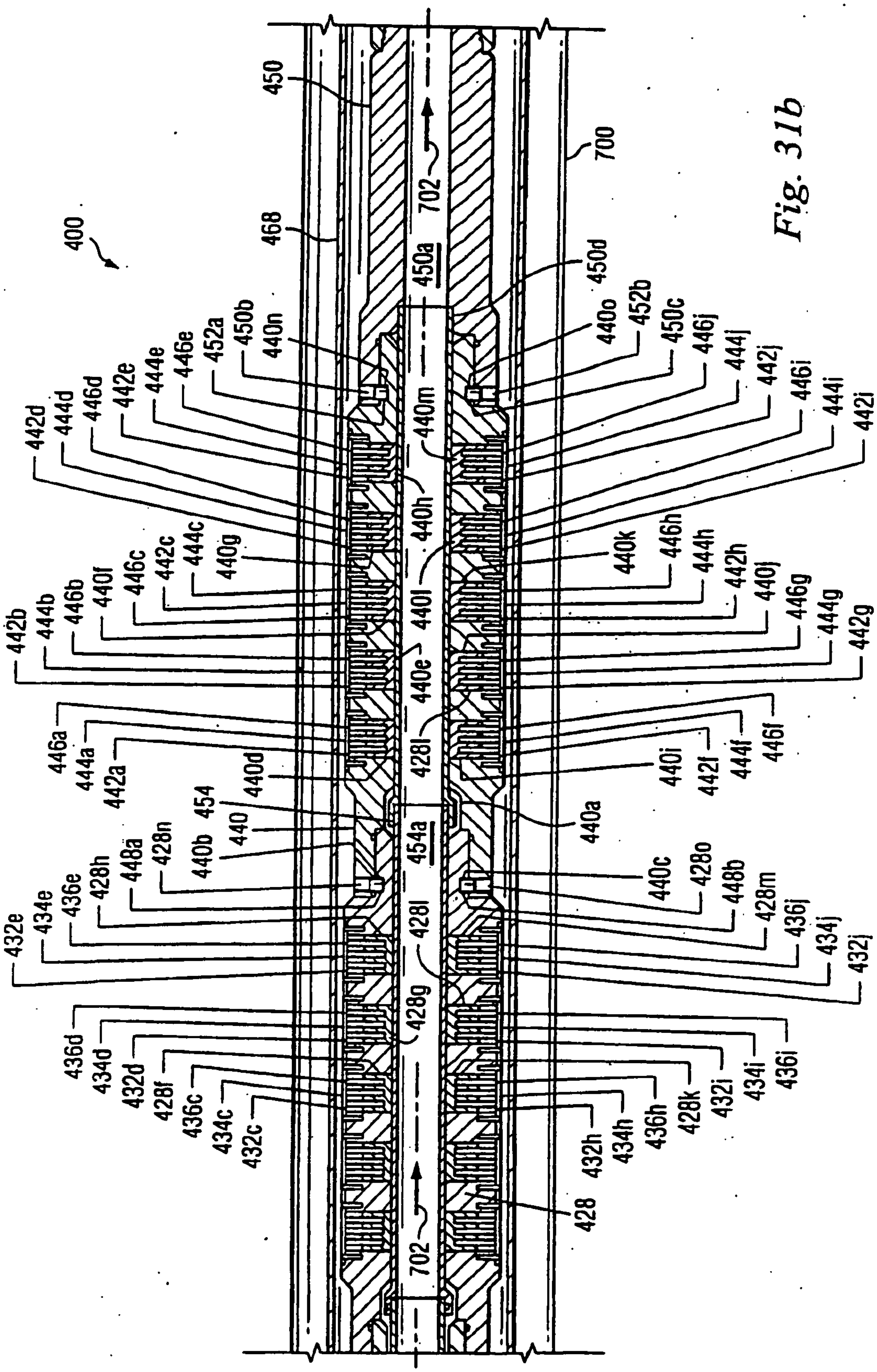

400
450
468
702
700
450a
450d
450b
440n
452a
446e
444e
442e
446d
444d
442d
440o
452b
450c
446j
444j
442j
446i
444i
442i
440m
440h
440g
444c
442c
446c
440f
446b
444b
442b
440k
446h
444h
442h
440j
446g
444g
442g
440l
440e
428l
446a
444a
442a
440i
442f
444f
446f
440d
454
440
440b
428n
448a
428h
436e
434e
432e
454a
440a
440c
428o
448b
428m
436j
434j
432j
428g
436d
434d
432d
428f
436c
434c
432c
432i
434i
436i
428k
436h
434h
432h
428

Fig. 31b

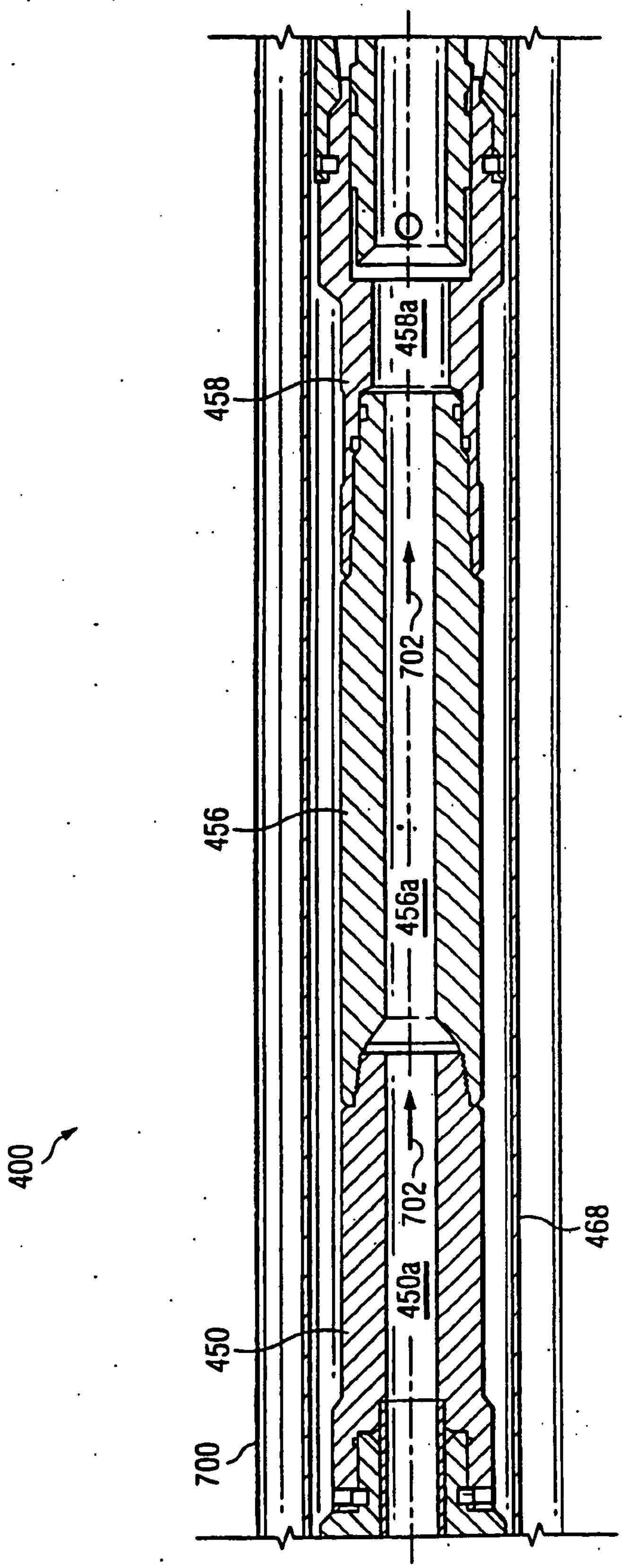
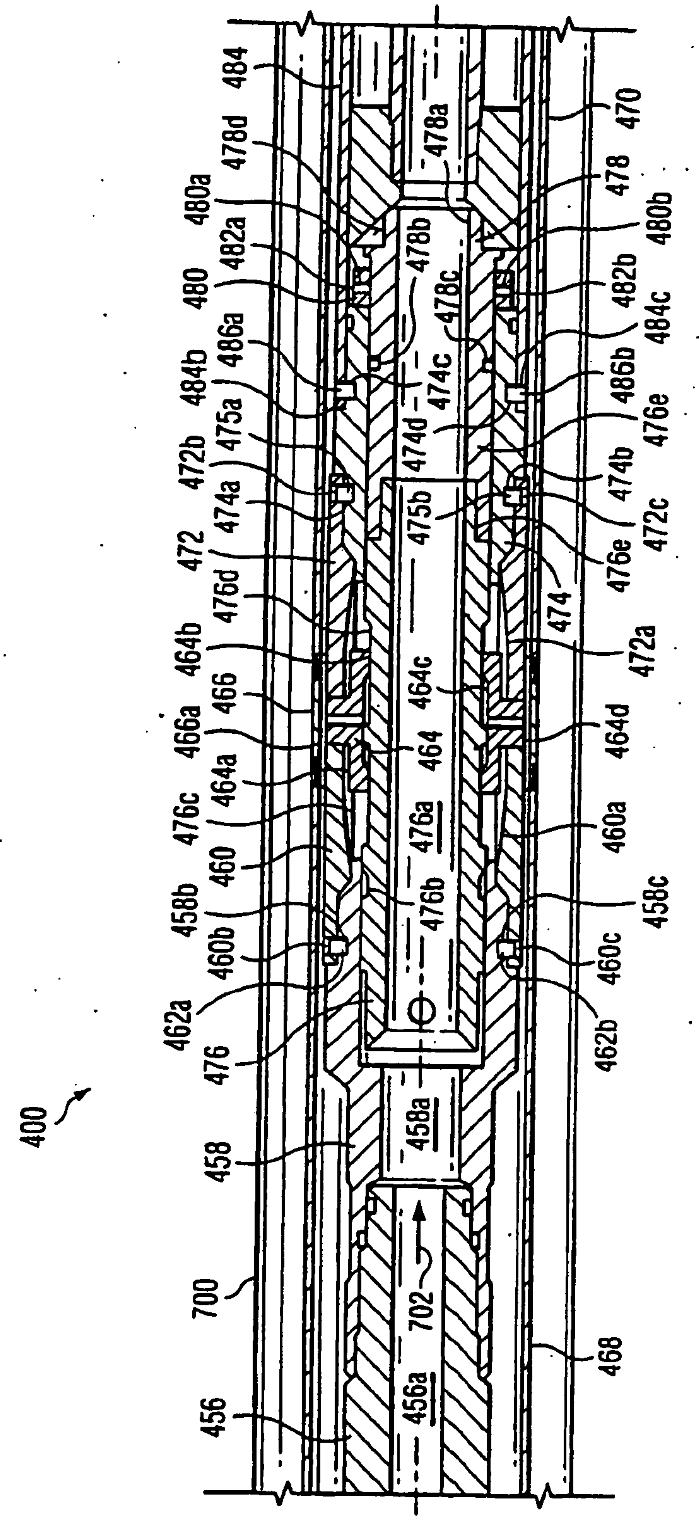


Fig. 31c



400
456
456a
700
702
468
458
458a
476
462a
460b
458b
460
476c
464a
466a
466
464b
476d
472
474a
472b
475a
484b
486a
480
482a
480a
478d
484
478a
478
470
480b
482b
484c
486b
476e
474b
472c
476e
474
472a
464d
460a
458c
460c
462b
476a
476b
464
464c
475b
474d
474c
478c
478b

Fig. 31d

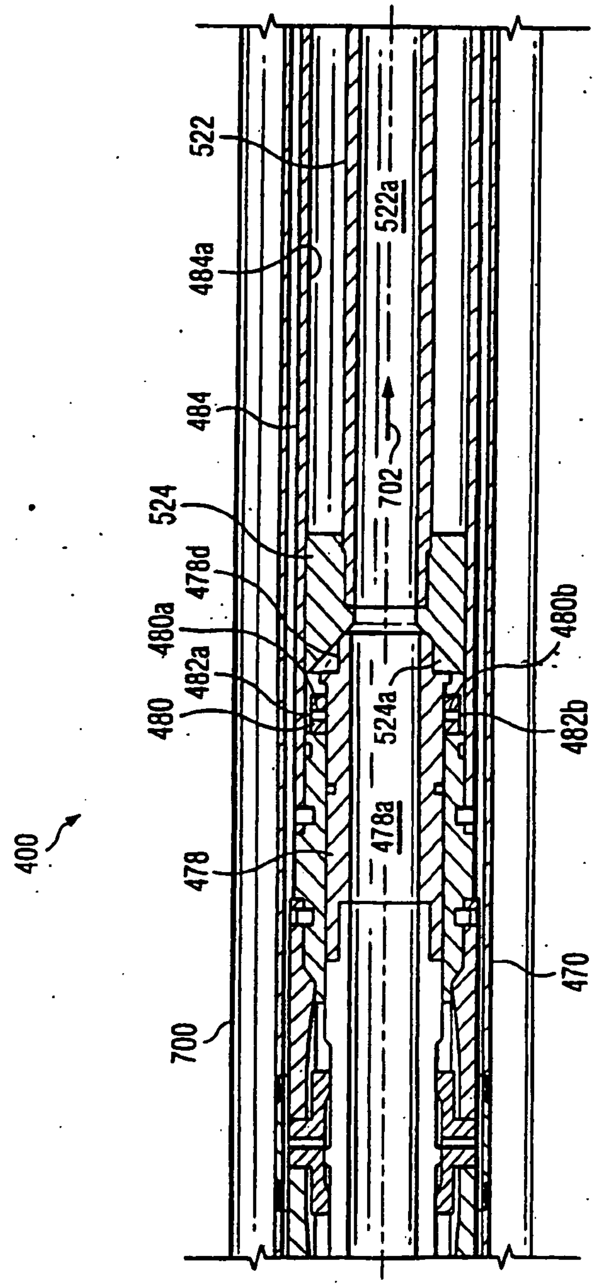
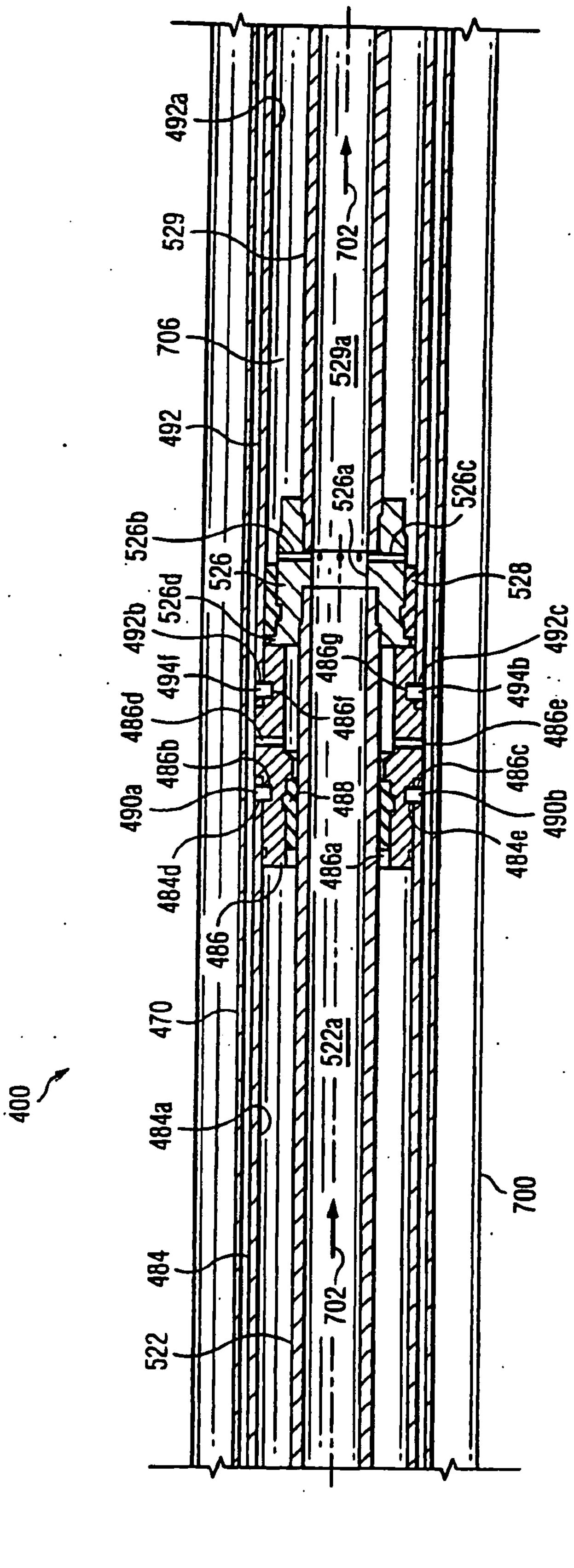

400
522
522a
484a
484
702
524
478d
480a
482a
480
524a
478
478a
700
480b
482b
470

Fig. 31e



400
492a
529
706
492
526b
526
526a
526c
526d
492b
528
492c
702
529a
494f
486g
494b
486d
486f
486e
486b
486c
490a
488
490b
484d
486a
484e
486
470
522a
484a
700
484
702
522

Fig. 31f

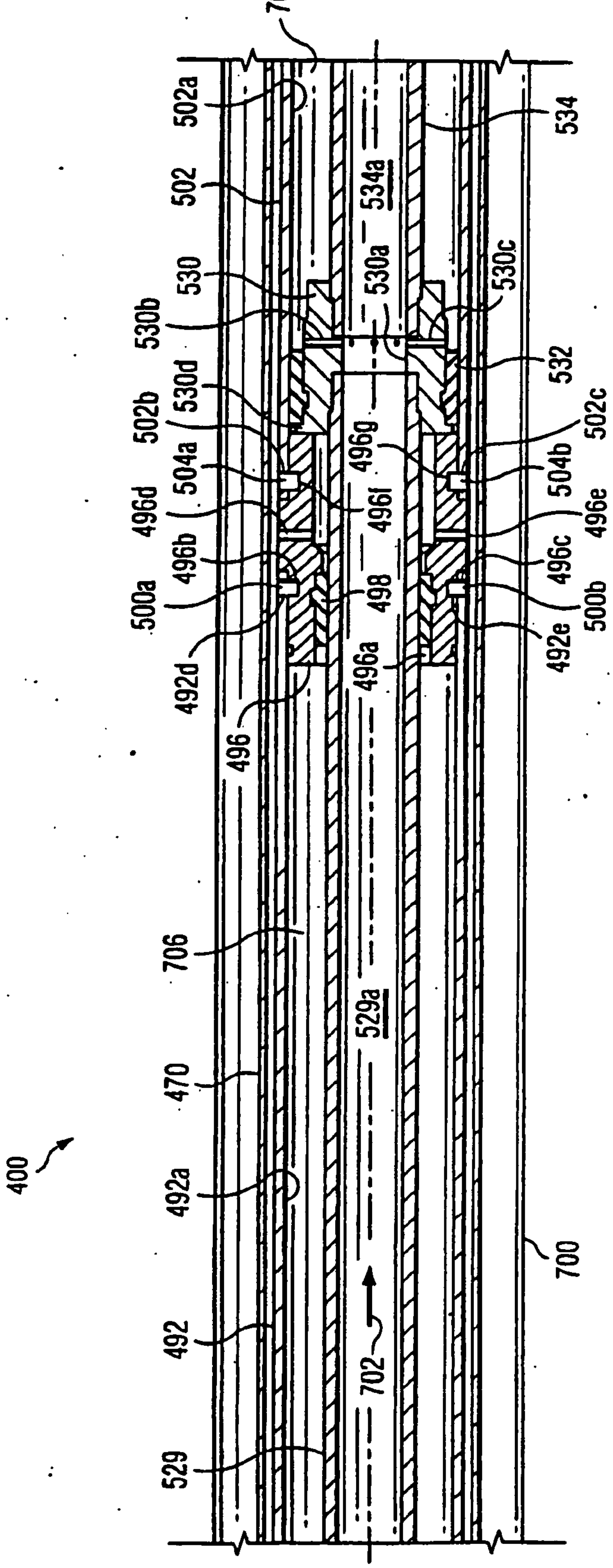
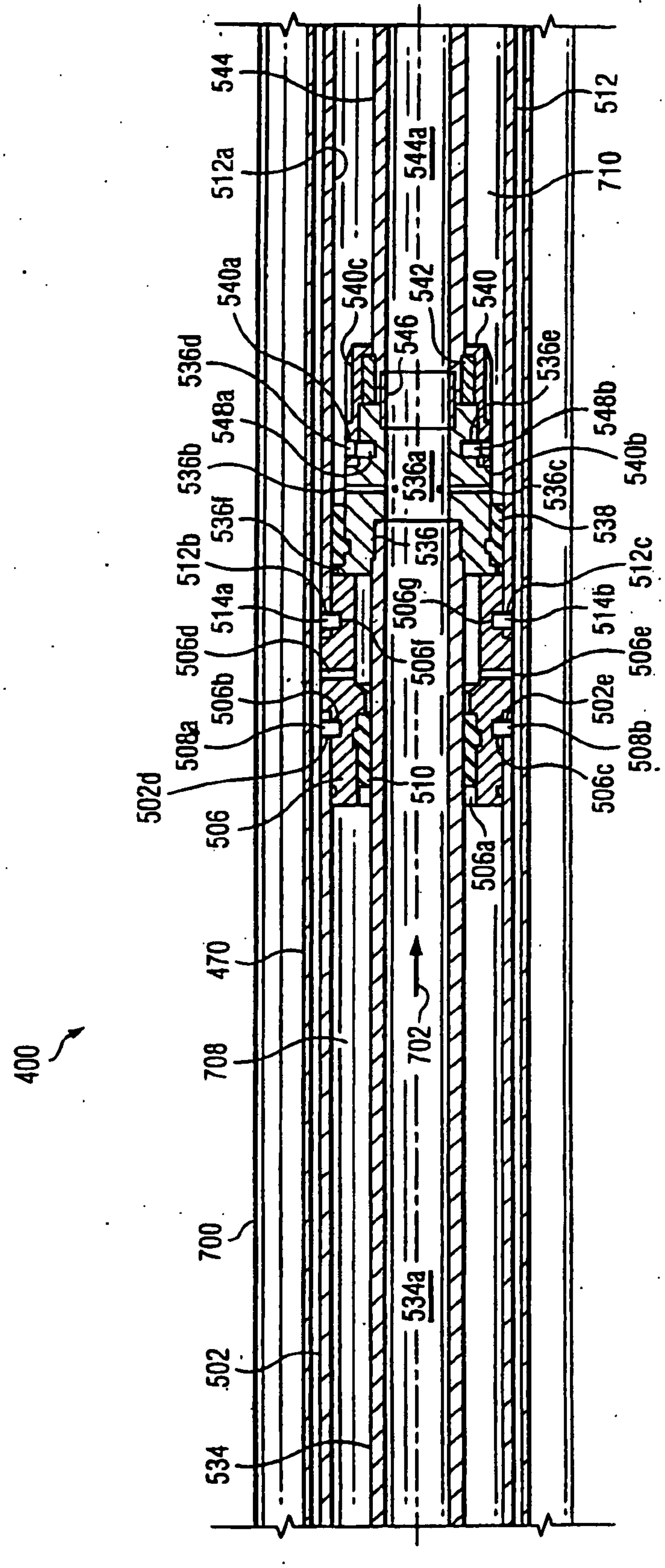

400
708
502a
502
530
530b
530d
502b
504a
496d
496b
500a
492d
496
706
470
492a
492
529
534
534a
530a
530c
532
502c
496g
504b
496f
496e
496c
500b
498
492e
496a
529a
702
700

Fig. 31g



544
512a
544a
710
512
540a
540c
546
542
540
536d
536e
548a
548b
536b
536a
536c
540b
536f
536
538
512b
506g
512c
514a
514b
506d
506f
506e
506b
502e
508a
508b
502d
510
506c
506
506a
470
702
400
708
700
534a
502
534

Fig. 31h

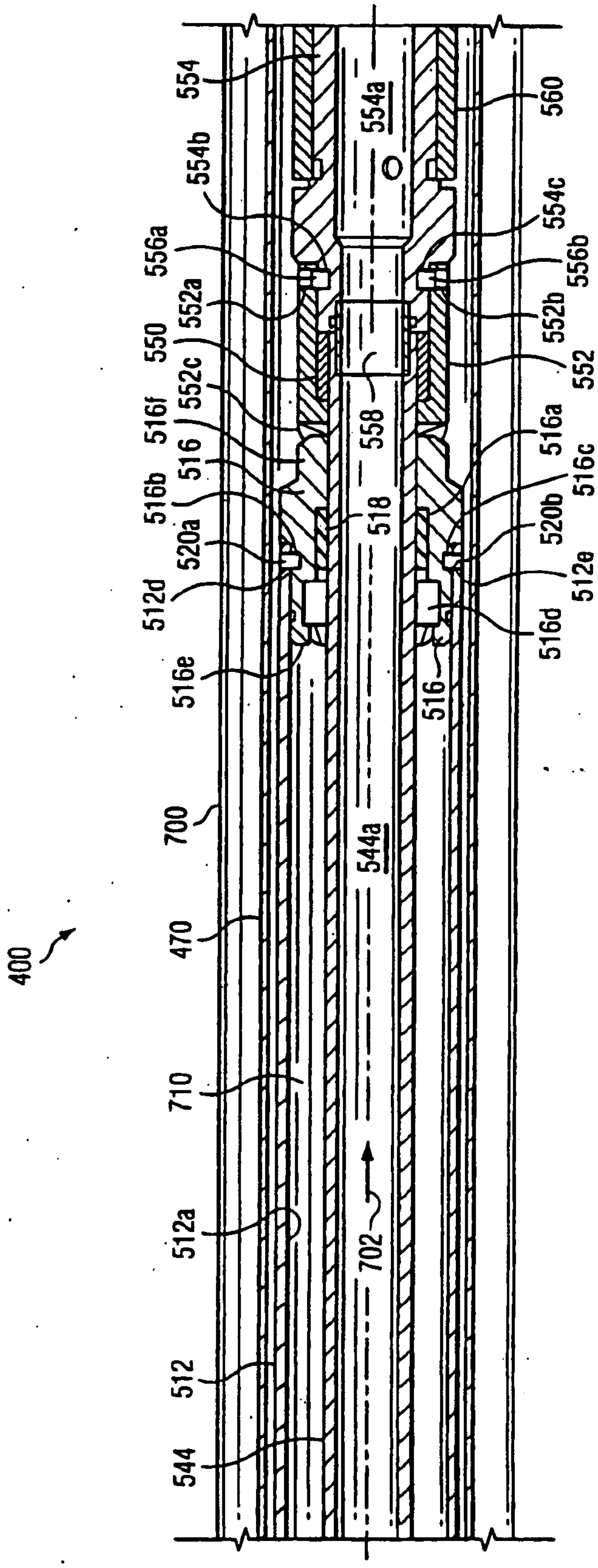
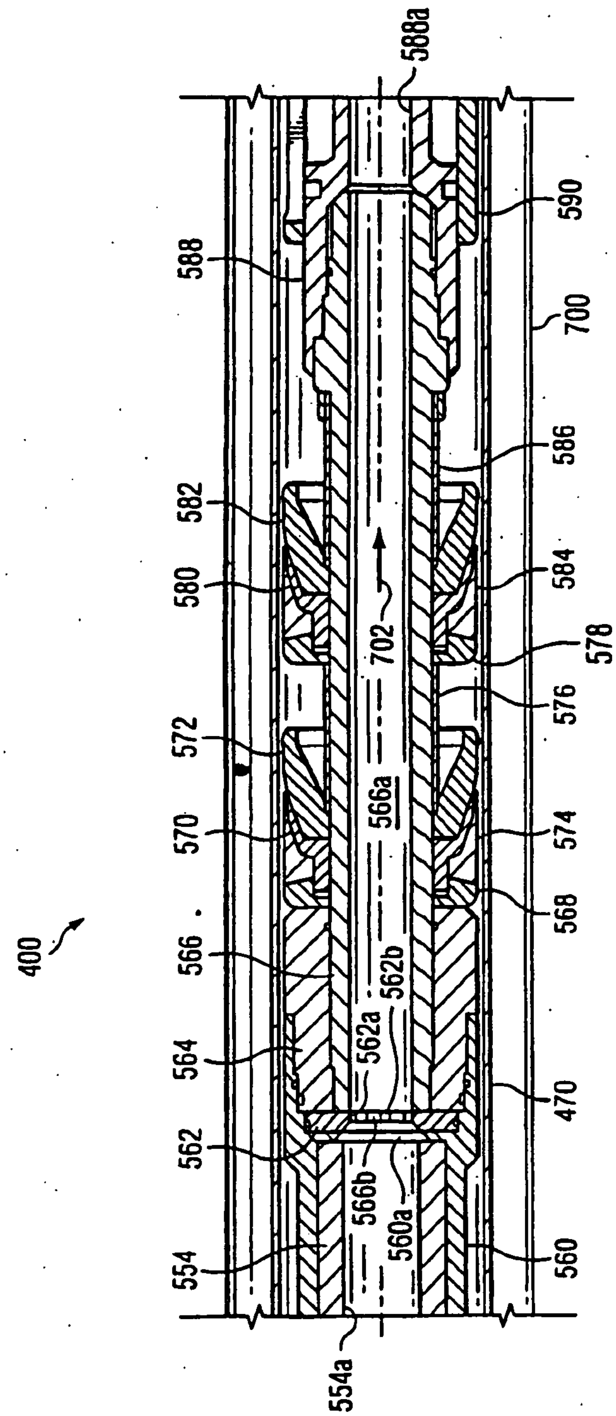
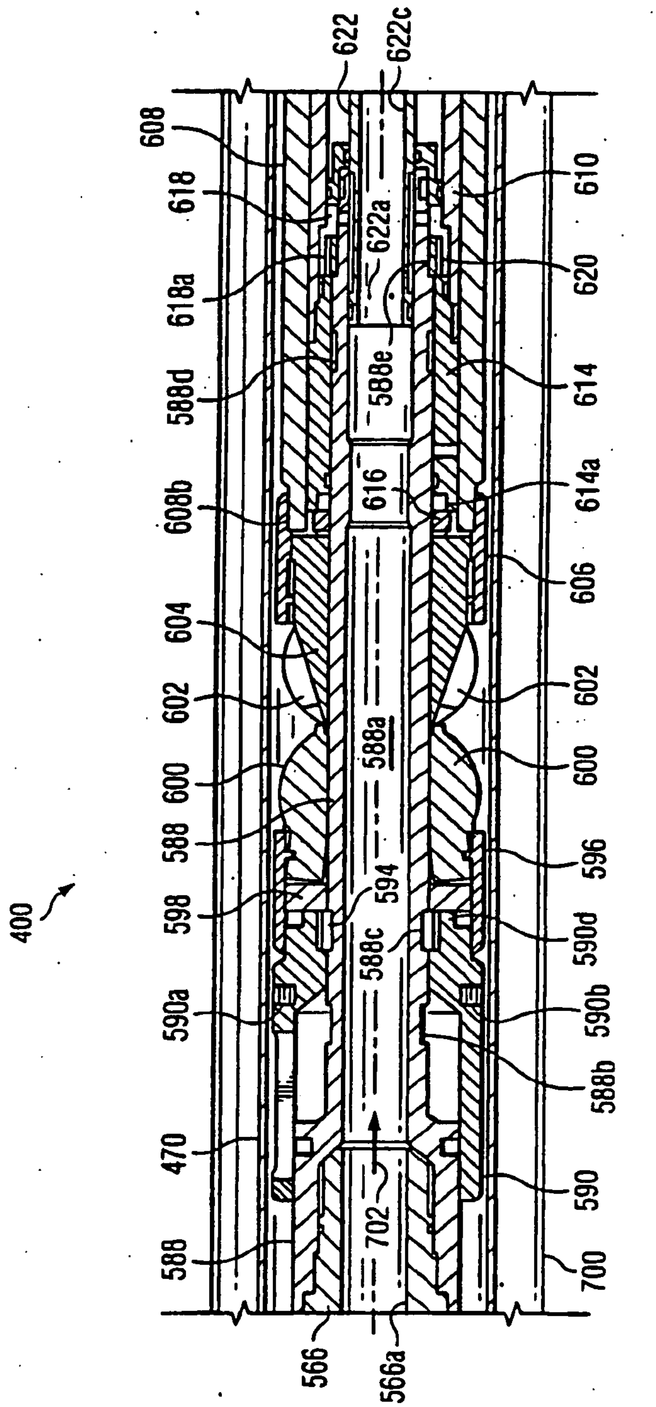

554
554a
560
554b
554c
556a
556b
552a
552b
550
552
552c
558
516f
516a
516
516c
516b
518
520a
520b
512d
512e
516d
516e
516
700
544a
470
400
710
512a
702
512
544

Fig. 31i



400
588a
590
588
700
586
582
584
580
578
702
576
572
566a
574
570
568
566
562b
562a
564
470
562
566b
560a
554
560
554a

Fig. 31j



400
608
618
618a
588d
608b
604
602
600
588
598
590a
470
588
566
566a
702
588c
594
588a
616
588e
622a
622
622c
610
620
614
614a
606
602
600
596
590d
590b
588b
590
700

Fig. 31k

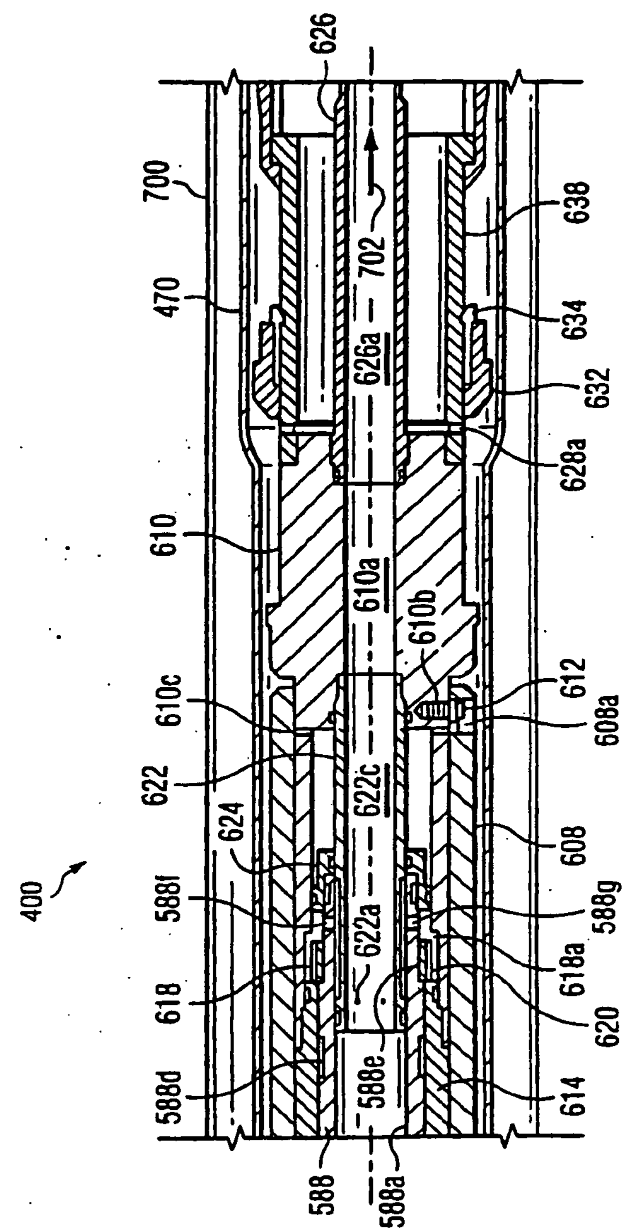

400
626
700
470
702
626a
638
634
632
628a
610
610a
610b
610c
612
608a
622
622c
624
608
588f
588g
622a
618a
618
620
588d
588e
614
588
588a

Fig. 31l

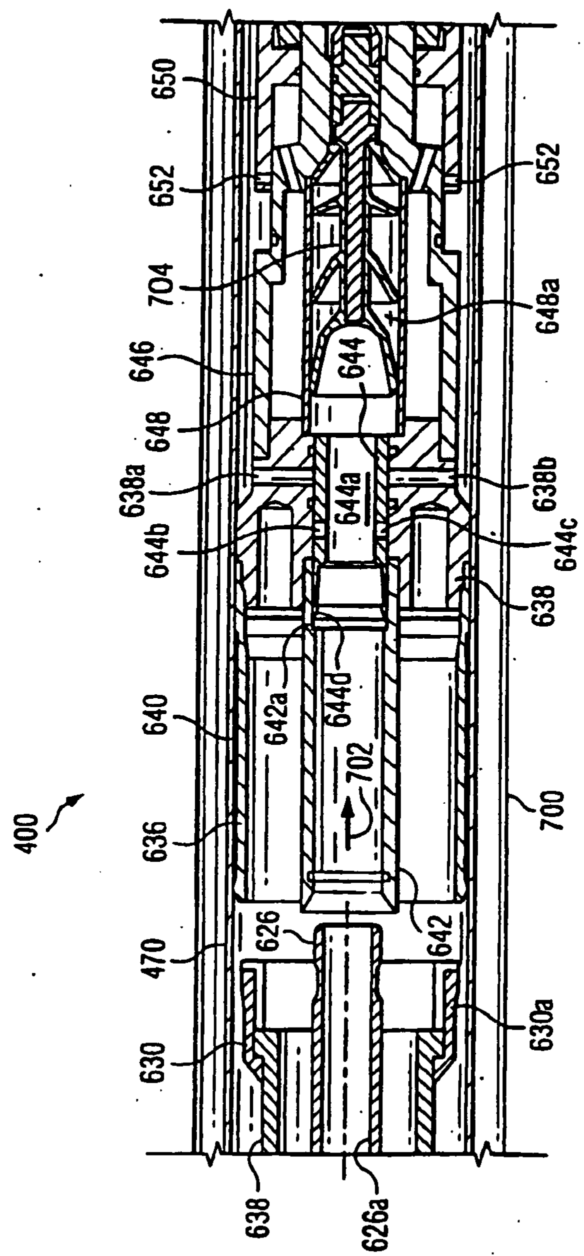

400
650
652
704
646
648
638a
644b
640
636
470
630
638
626a
626
642a
644d
702
642
644
644a
648a
652
638b
644c
638
700
630a

Fig. 31m

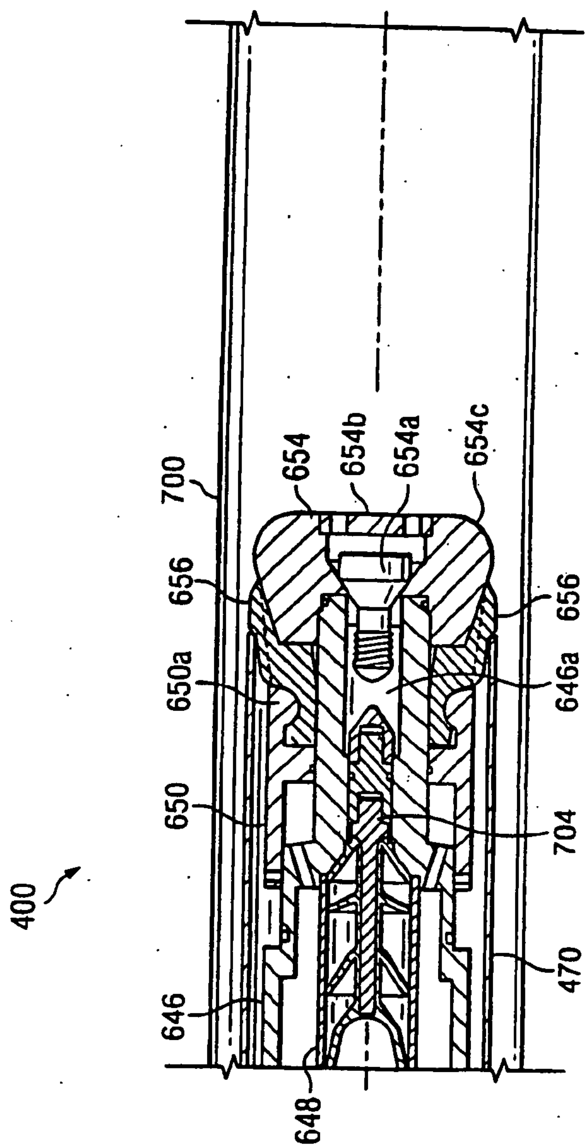

700
654
654b
654a
654c
656
656
650a
646a
650
704
400
646
470
648

Fig. 31n

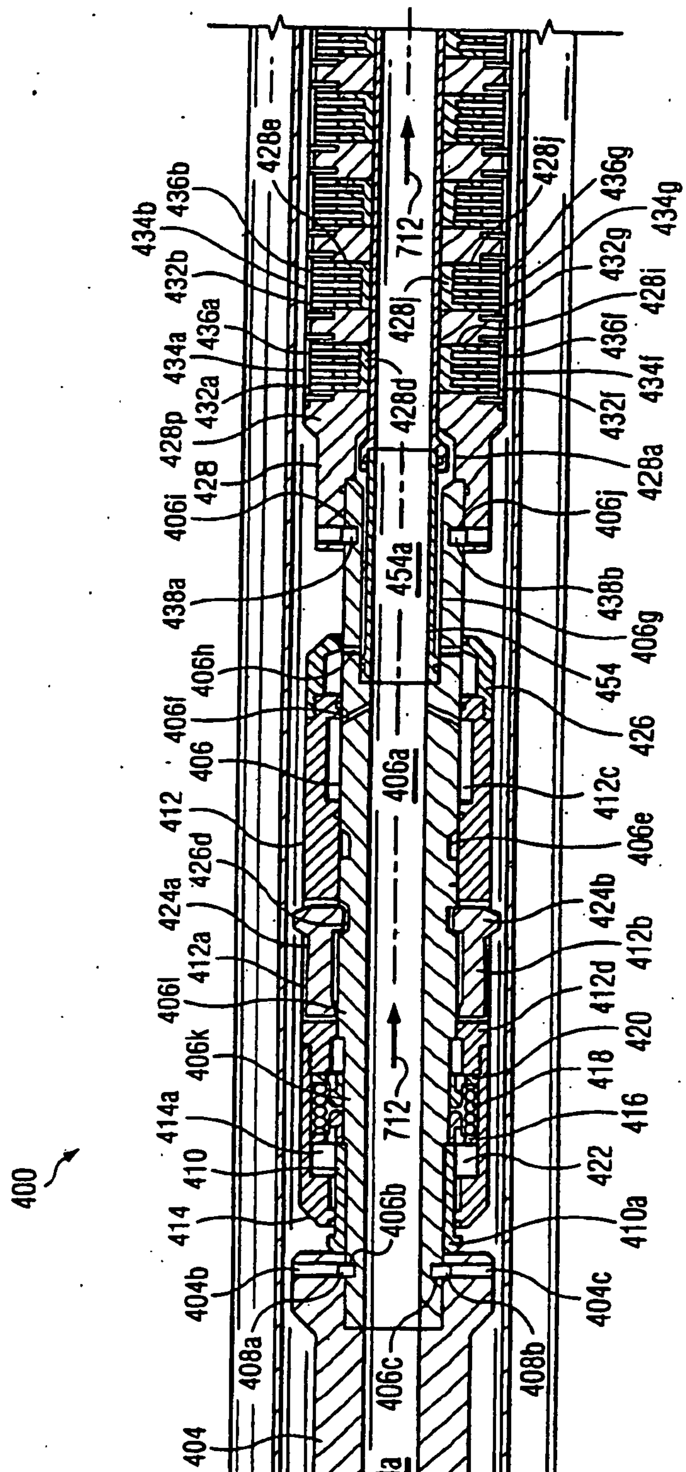

400
700
402
404
402a
404a
406c
408a
408b
404b
404c
406b
414
410
410a
414a
406k
406l
412a
424a
426d
412
406
406f
406h
438a
406i
428
428p
432a
434a
436a
432b
434b
436b
428e
712
428d
428i
428j
428a
406j
438b
406g
454
454a
426
406a
412c
406e
424b
412b
412d
420
418
416
422
432f
434f
436f
428i
432g
434g
436g
468

Fig. 32a.

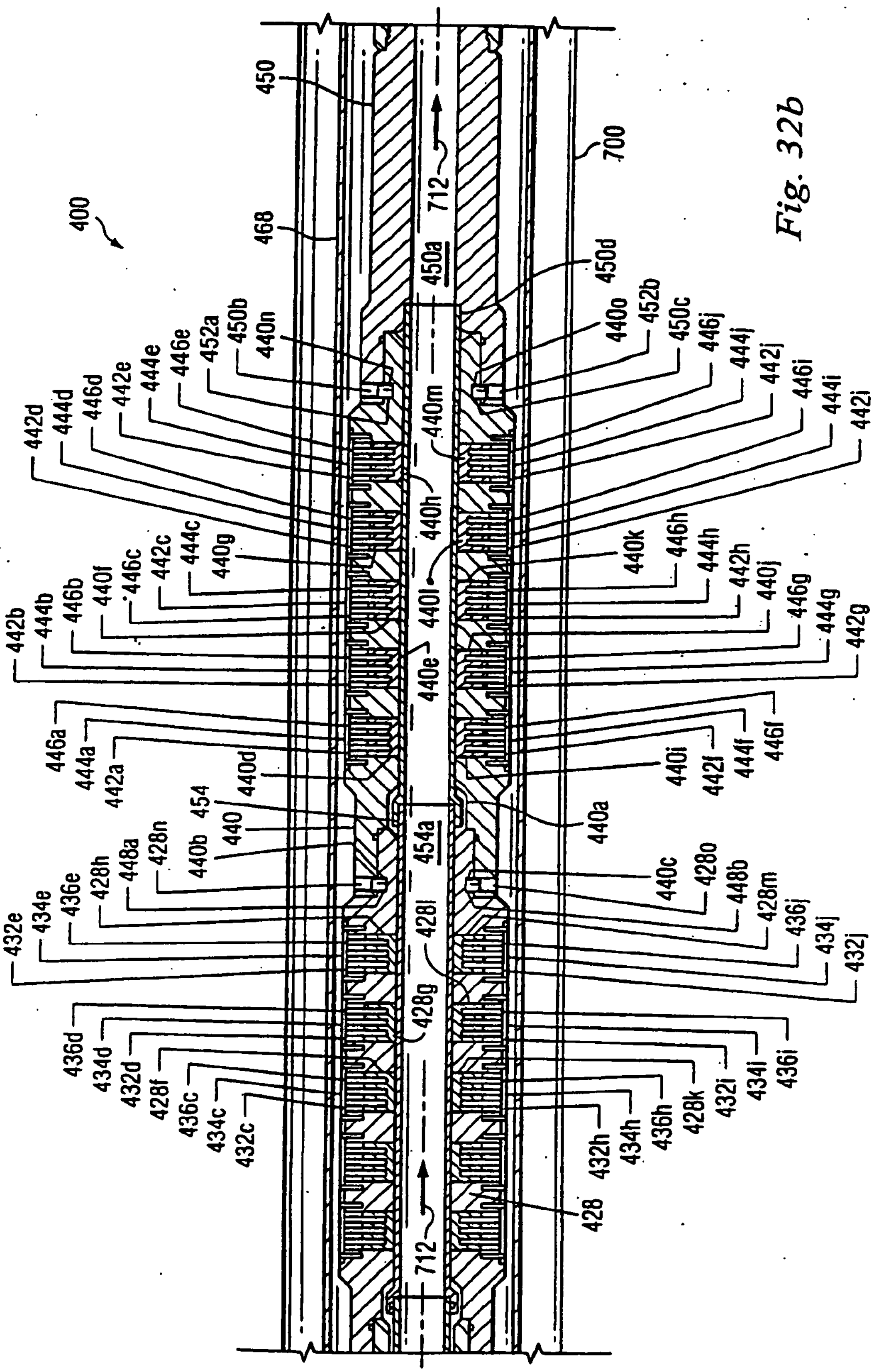

400
450
468
700
712
450a
450d
450b
440n
452a
446e
444e
442e
446d
444d
442d
440o
452b
450c
446j
444j
442j
446i
444i
442i
440m
440h
440g
444c
442c
446c
440f
446b
444b
442b
440k
446h
444h
442h
440j
446g
444g
442g
440l
440e
446a
444a
442a
440d
454
440
440b
428n
448a
428h
436e
434e
432e
440i
442f
444f
446f
440a
454a
440c
428o
448b
428m
436j
434j
432j
428l
428g
436d
434d
432d
428f
436c
434c
432c
432h
434h
436h
428k
432i
434i
436i
428
712

Fig. 32b

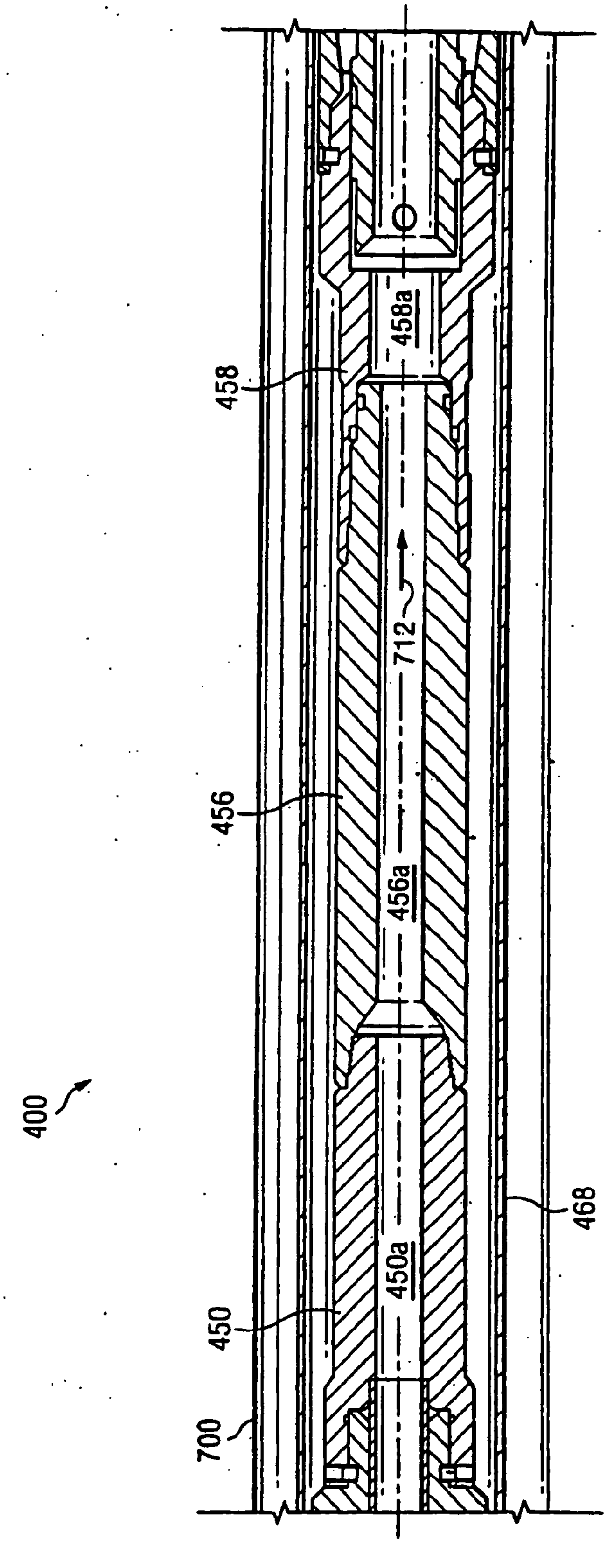


Fig. 32c

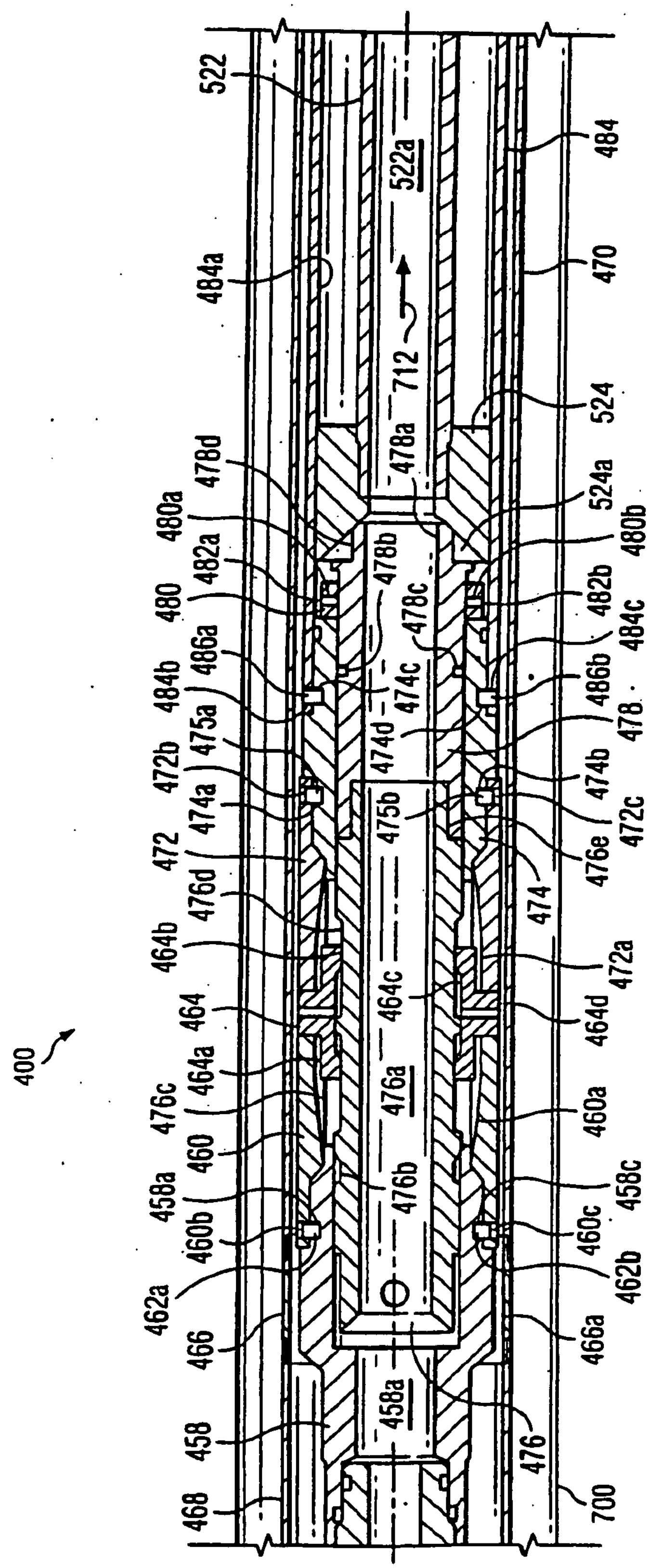

522
522a
484
484a
470
712
524
478a
478d
480a
524a
480b
482a
478b
480
482b
478c
484c
486a
484b
474c
486b
475a
474d
478
472b
474b
474a
475b
472c
472
476e
476d
474
464b
472a
464
464c
464d
400
464a
476a
476c
460a
460
476b
458a
458c
460b
460c
462a
462b
466
466a
458
458a
476
468
700

FIG. 32d

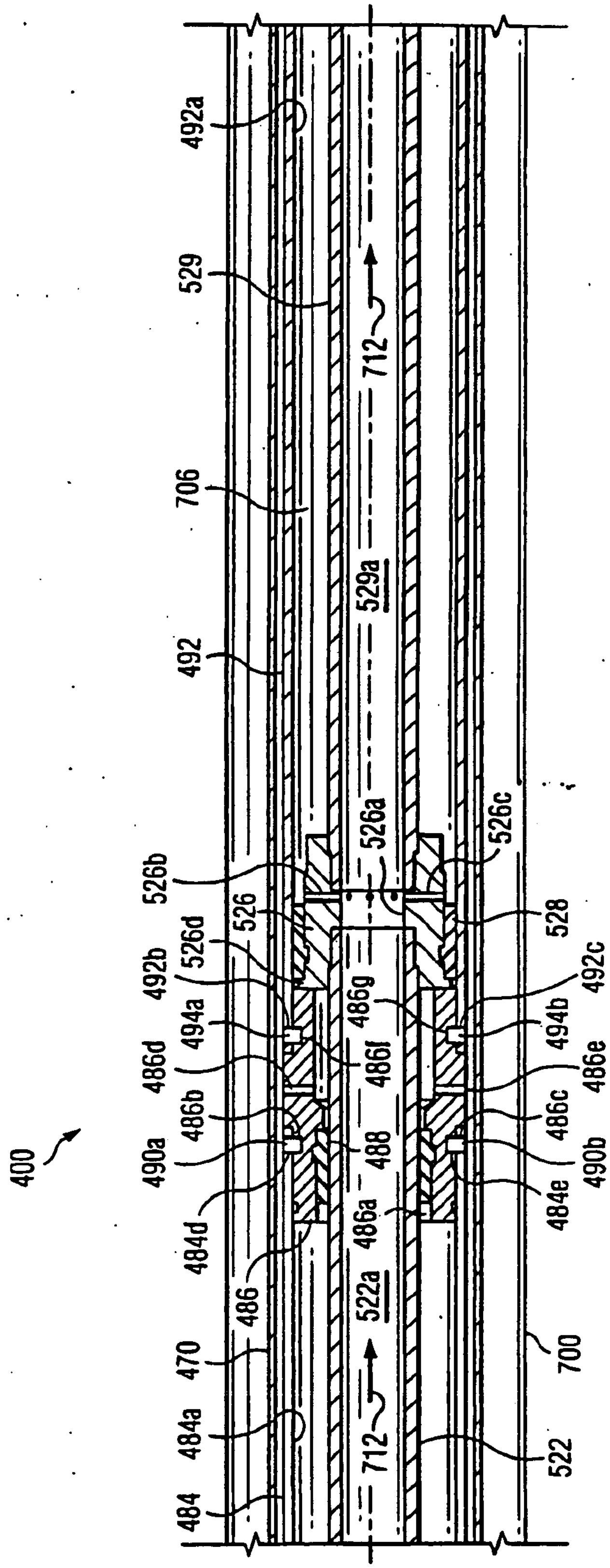

400
492a
529
706
492
712
529a
526a
526c
526b
526
528
526d
492b
492c
486g
494a
494b
486d
486f
486e
486b
486c
490a
488
490b
484d
486a
484e
486
522a
470
700
484a
712
522
484

Fig. 32e

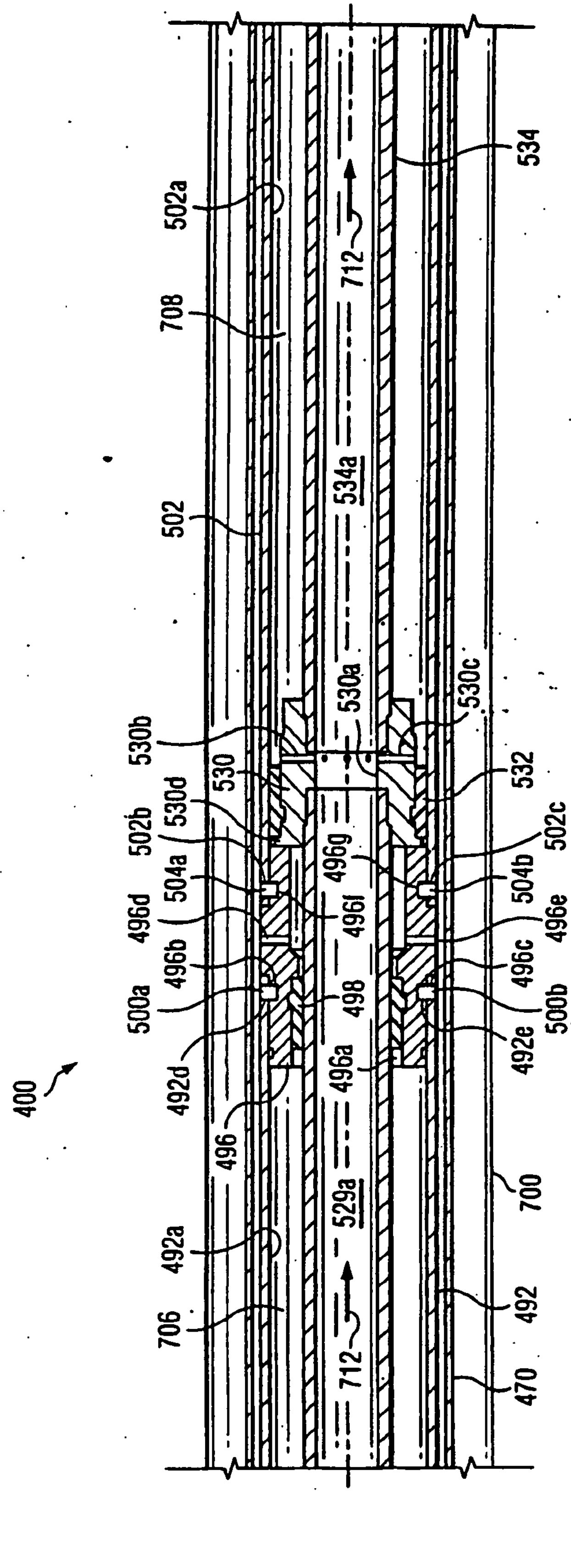

400
502a
708
502
534
712
534a
530a
530b
530c
530
530d
502b
504a
496d
496b
500a
492d
496
492a
706
712
529a
496a
498
496f
496g
532
502c
504b
496e
496c
500b
492e
700
492
470

Fig. 32f

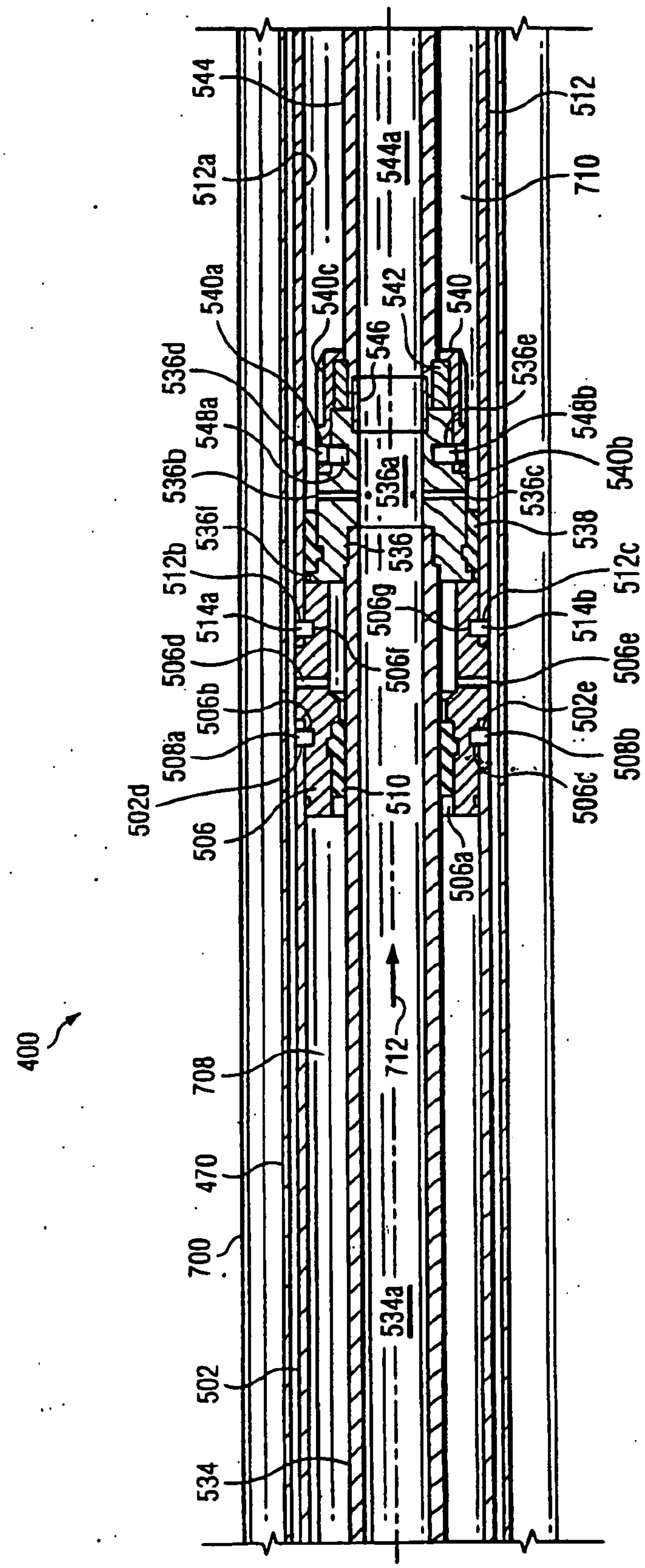
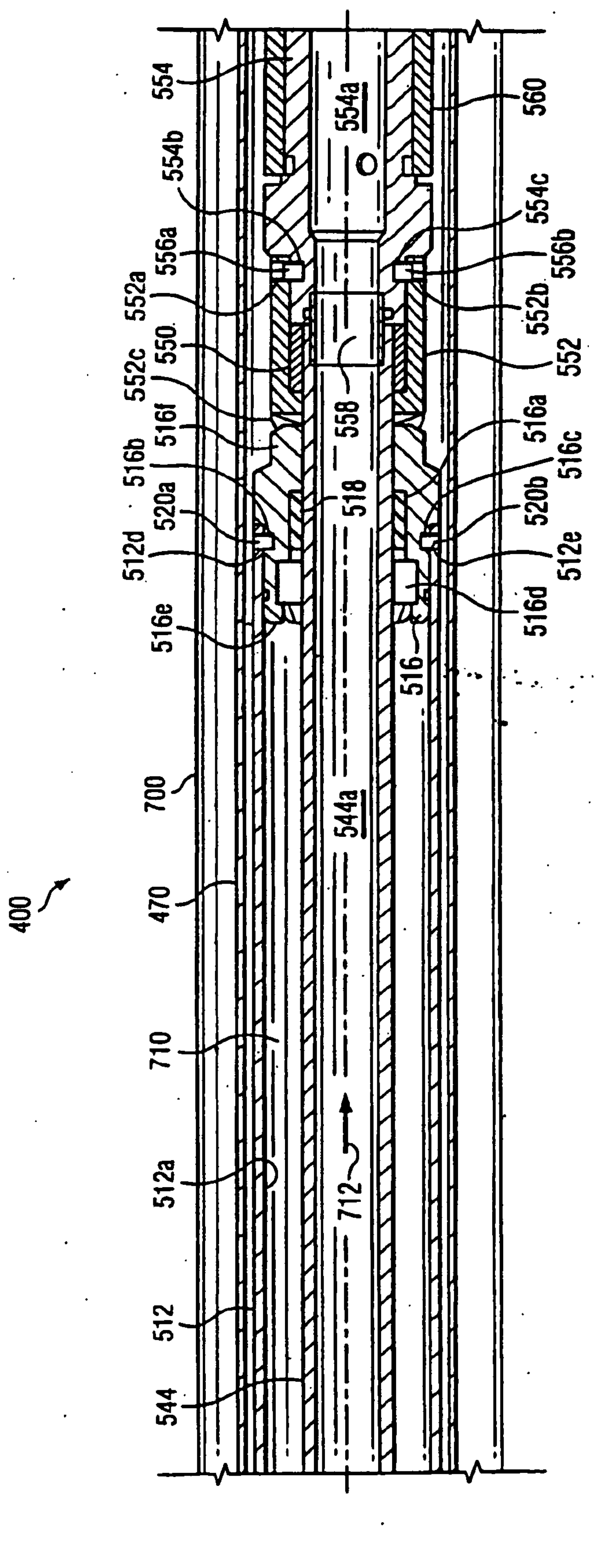

400
544
512a
540a
540c
542
540
546
536d
548a
536b
536f
512b
514a
506d
506b
508a
502d
506
536e
548b
540b
536a
536c
538
536
512c
506g
514b
506f
506e
502e
508b
506c
510
506a
544a
512
710
708
470
700
502
534
712
534a

Fig. 32g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554a
560
554b
554c
556a
556b
552a
552b
552c
550
552
558
516f
516a
516b
518
516c
520a
520b
512d
512e
516d
516e
516
700
544a
400
470
710
512a
712
512
544

Fig. 32h

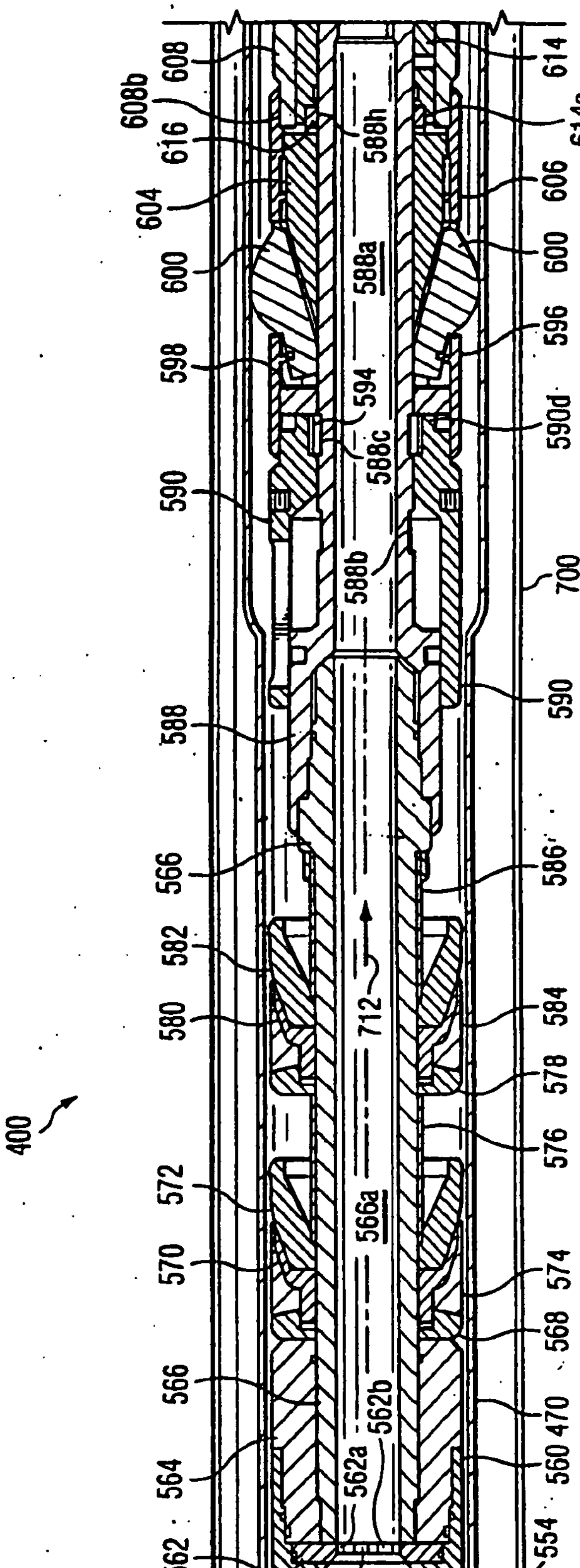

400
608
608b
616
604
600
598
590
588
566
582
580
572
570
566
564
562
554a
588h
588a
594
588c
588b
712
566a
562a
562b
566a
614
614a
606
600
596
590d
700
590
586
584
578
576
574
568
470
560
554
560a

Fig. 32i

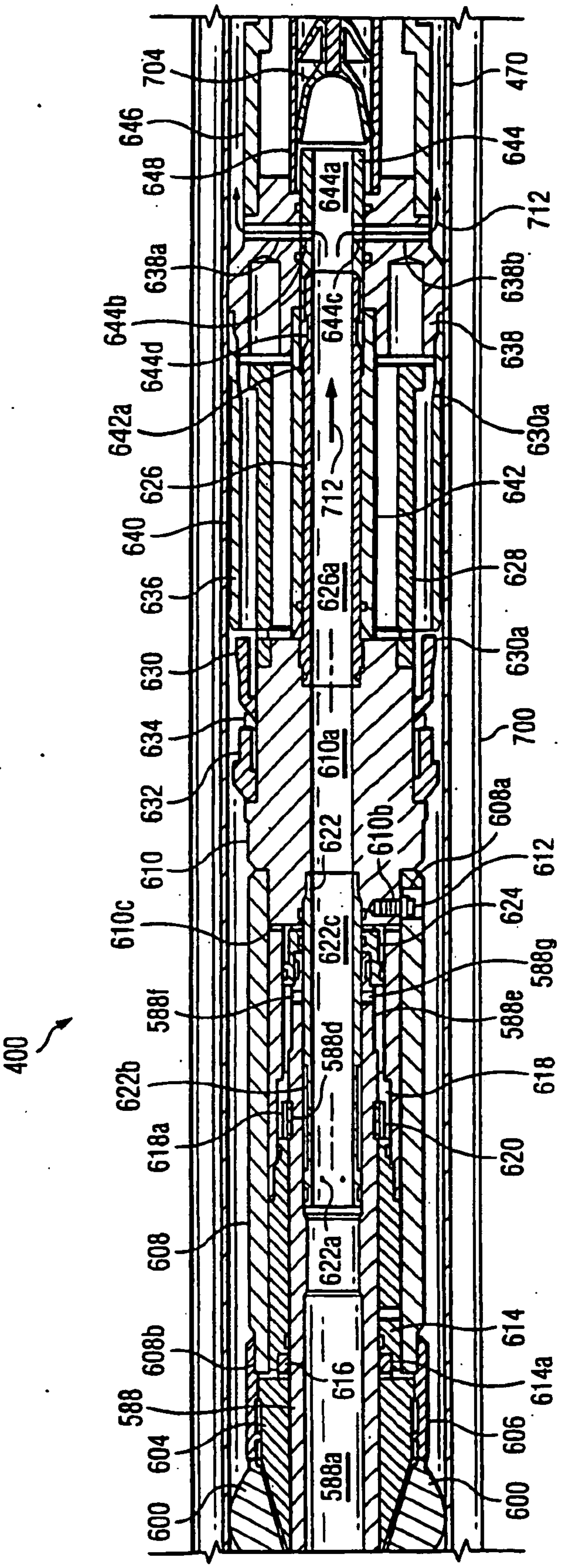

400
704
646
648
644
644a
712
470
638a
638b
644b
644c
644d
638
642a
630a
626
712
642
640
628
626a
636
630
630a
634
610a
700
632
622
610b
608a
610
612
610c
622c
624
588f
588g
588e
588d
622b
618
618a
620
608
622a
614
608b
616
614a
588
606
604
588a
600
600

Fig. 32j

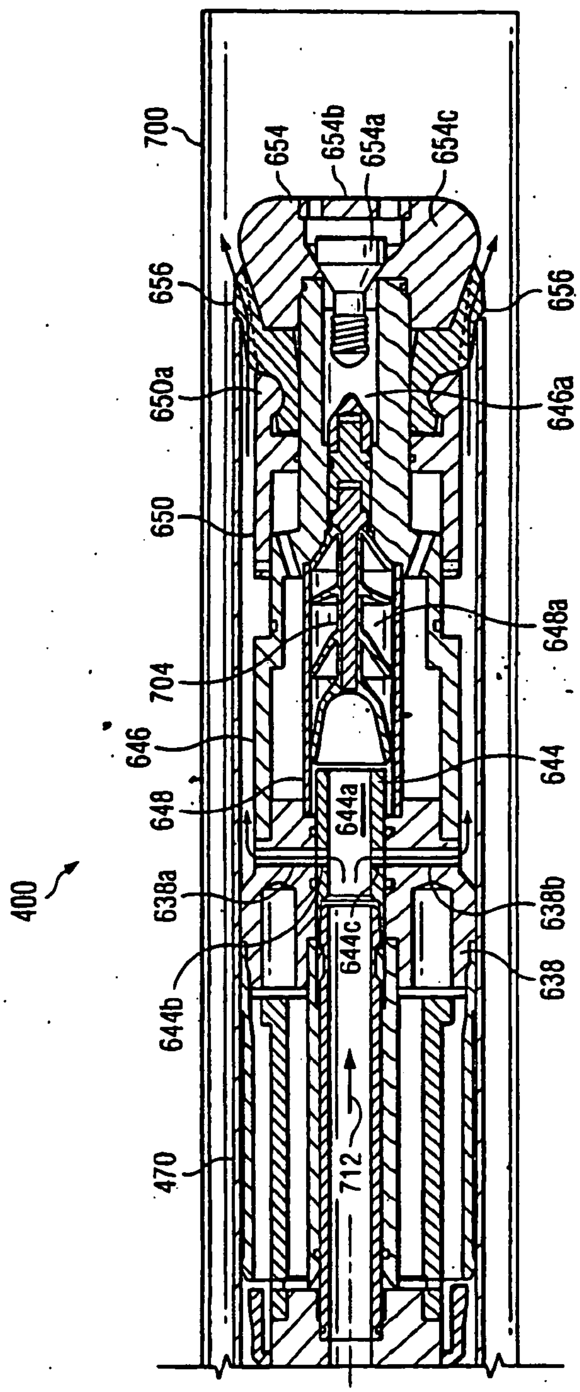

700
654
654b
654a
654c
656
656
650a
646a
650
648a
704
646
644
648
644a
400
638a
638b
644c
644b
638
470
712

Fig. 32k

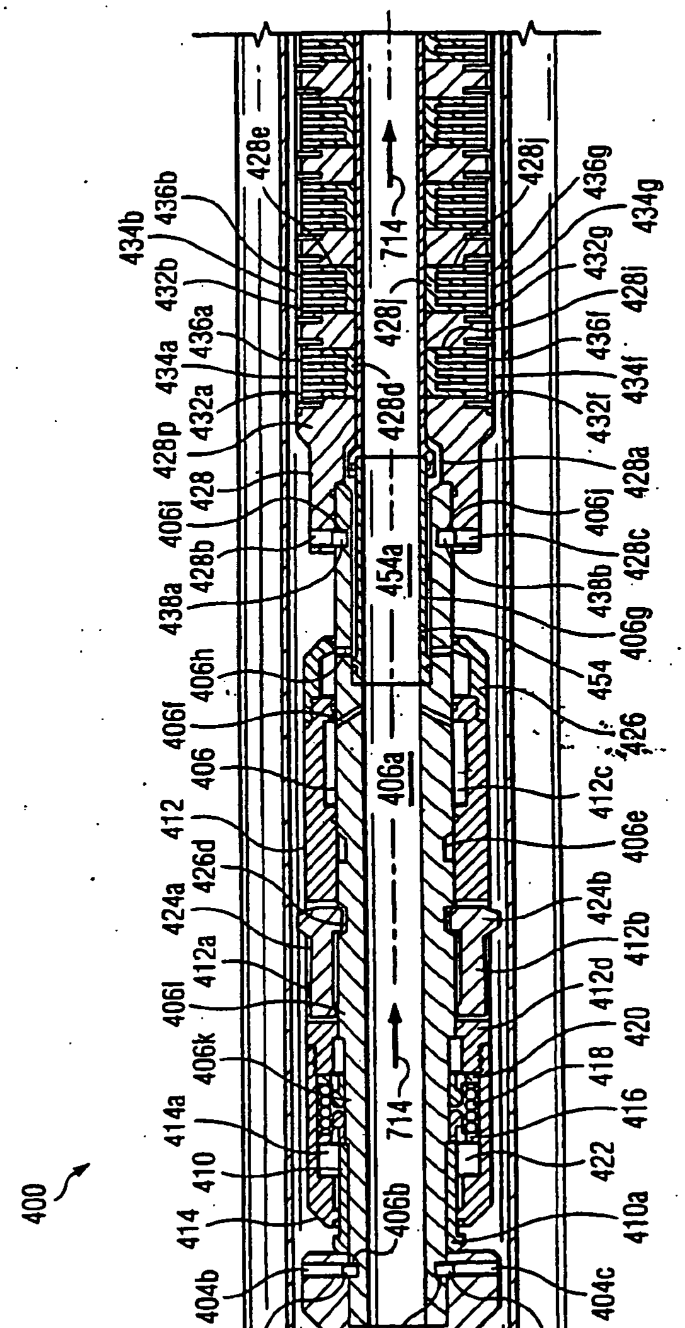

400
402
700
404
408a
404b
414
410
414a
406k
406l
412a
424a
426d
412
406
406f
406h
438a
428b
406i
428
428p
432a
434a
436a
432b
434b
436b
428e
714
428l
428d
454a
406a
406b
406c
404a
402a
468
408b
404c
410a
422
416
418
420
412d
412b
424b
406e
412c
426
454
406g
438b
428c
406j
428a
432f
434f
436f
428i
432g
434g
436g
428j

Fig. 33a

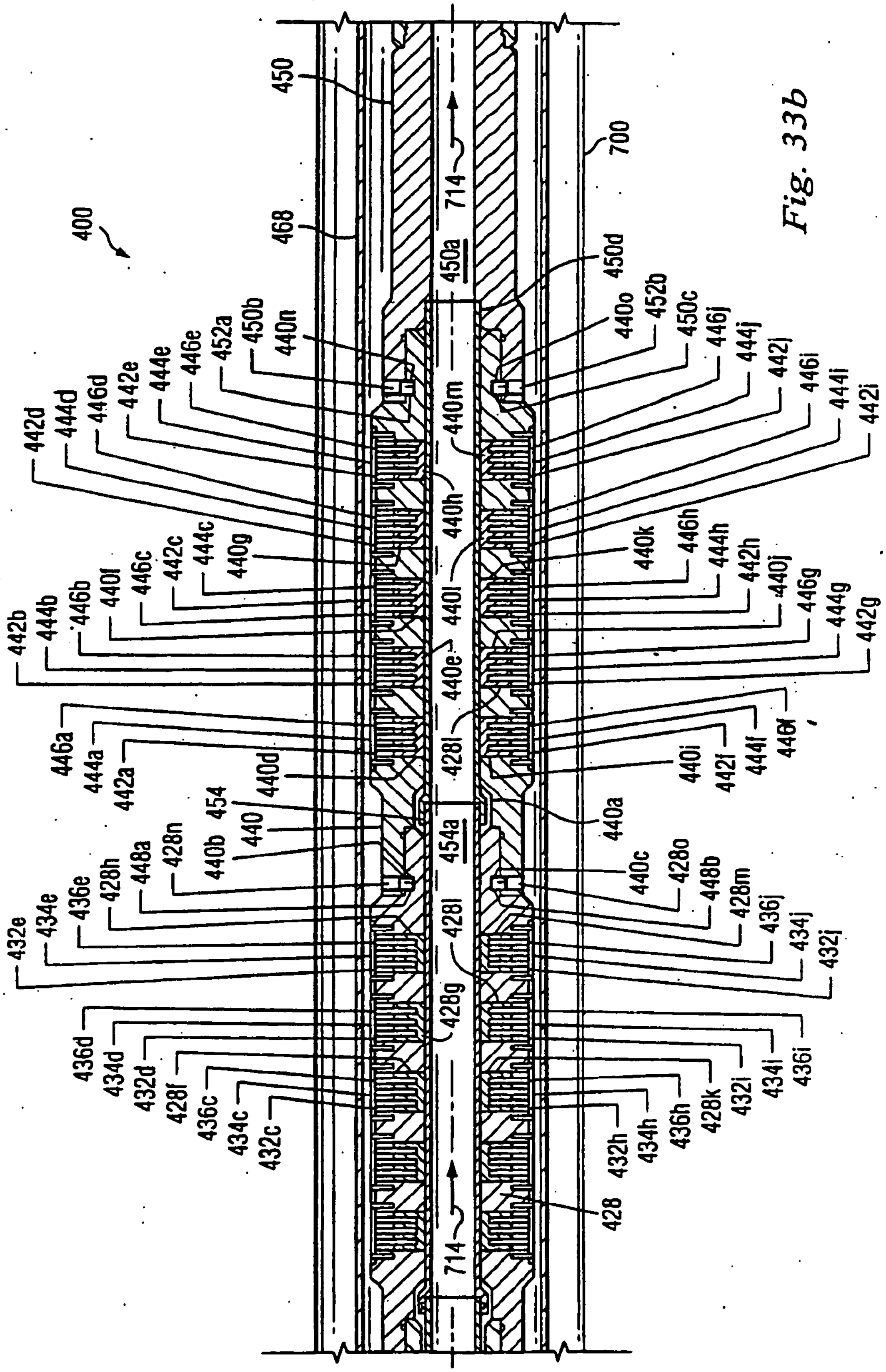

400
450
468
700
714
450a
450d
452b
450c
440o
446j
444j
442j
446i
444i
442i
440n
450b
452a
446e
444e
442e
446d
444d
442d
440m
440h
440g
444c
442c
446c
440f
446b
444b
442b
440k
446h
444h
442h
440j
446g
444g
442g
440l
440e
428l
446a
444a
442a
440d
454
440
440b
428n
448a
428h
436e
434e
432e
454a
440a
440i
442f
444f
446f
440c
428o
448b
428m
436j
434j
432j
428g
436d
434d
432d
428f
436c
434c
432c
432h
434h
436h
428k
432i
434i
436i
428

Fig. 33b

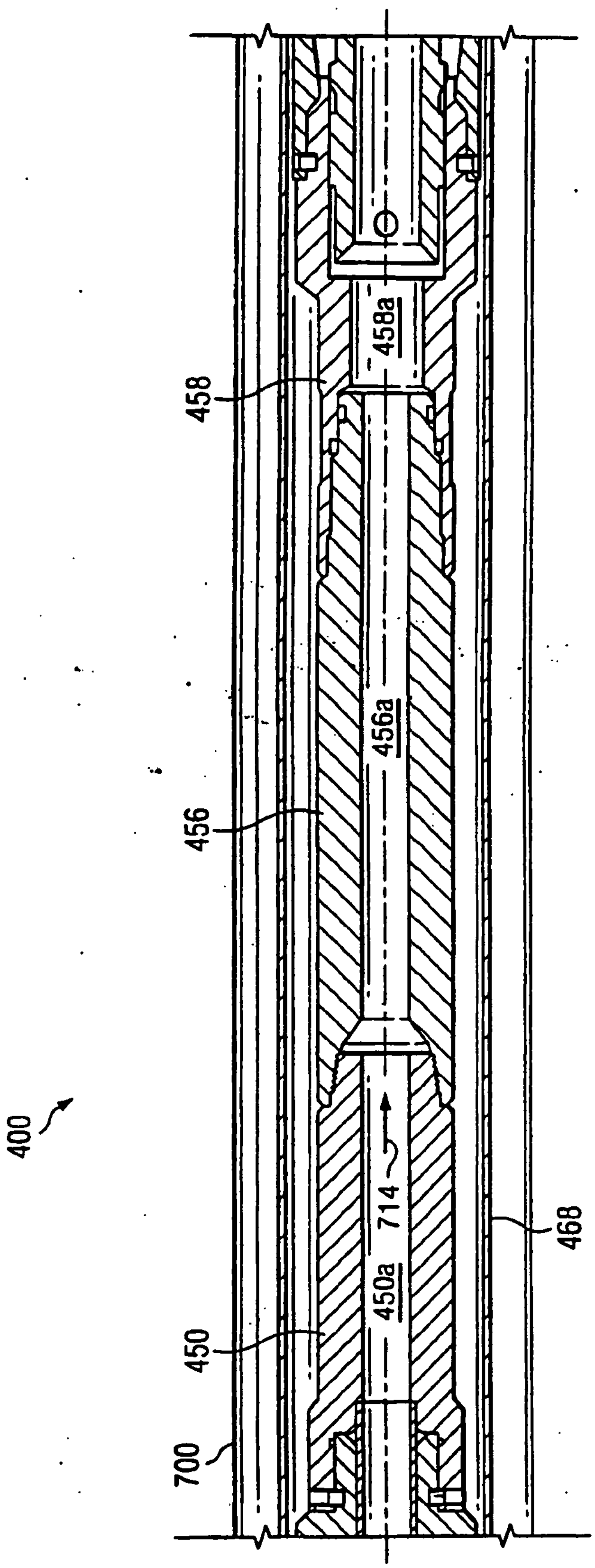


Fig. 33c

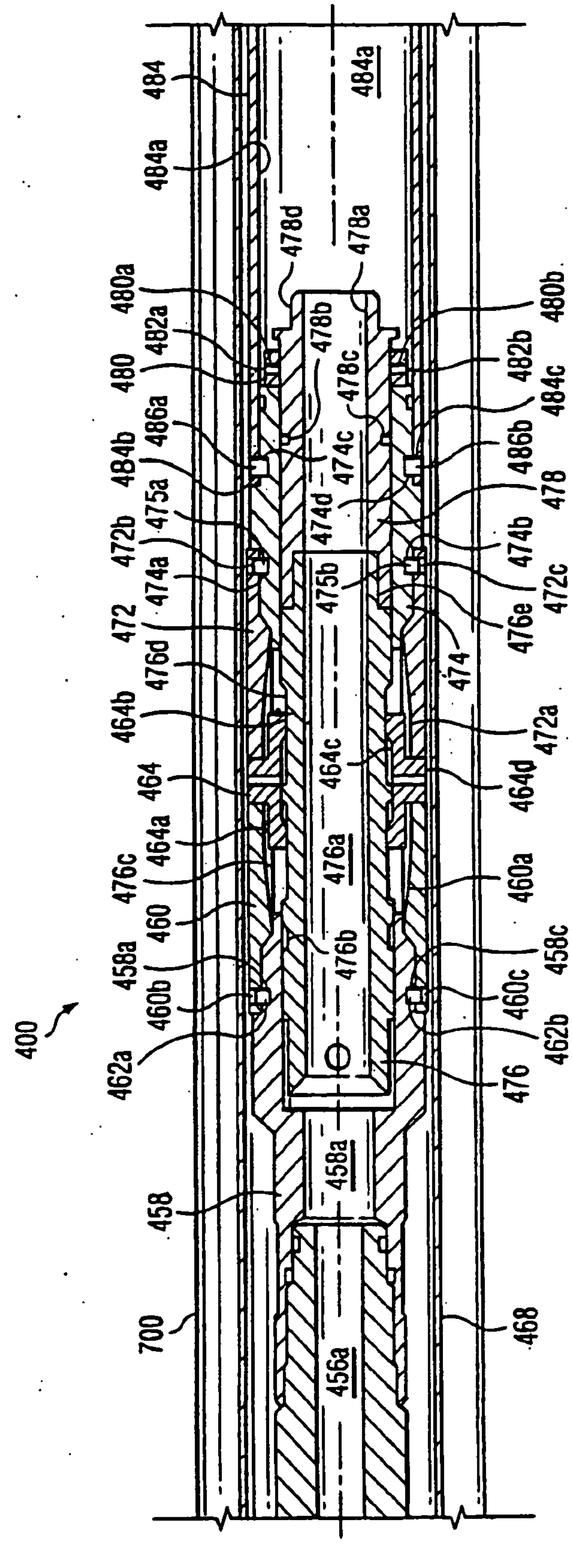

484
484a
484a
478d
478a
480a
482a
480
478b
478c
486a
484b
474c
475a
474d
472b
474a
475b
472
476d
464b
464c
464
464a
476a
476c
460
476b
458a
460b
400
462a
458a
458
700
456a
480b
482b
484c
486b
478
474b
472c
476e
474
472a
464d
460a
458c
460c
462b
476
468

Fig. 33d

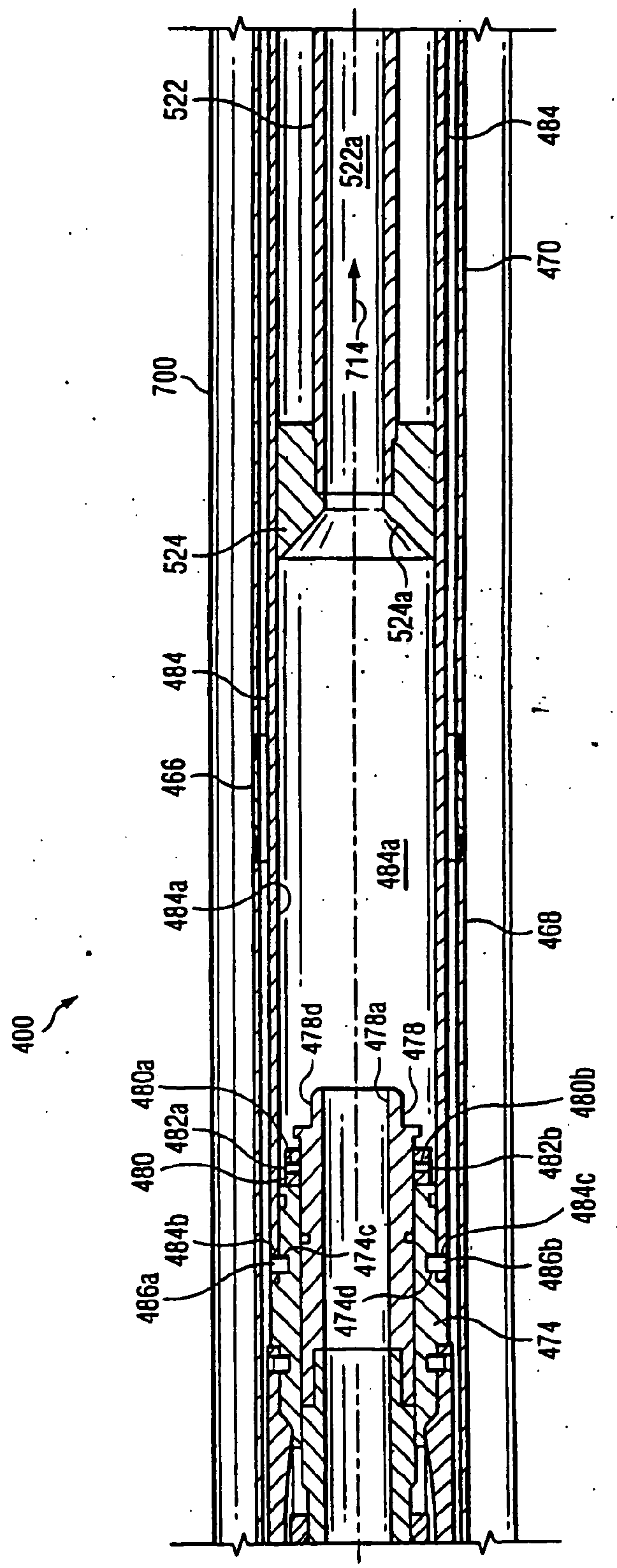

522
522a
714
484
470
700
524
524a
484
466
484a
484a
468
400
478d
478a
478
480a
482a
480
480b
482b
484b
474c
484c
486a
486b
474d
474

Fig. 33e

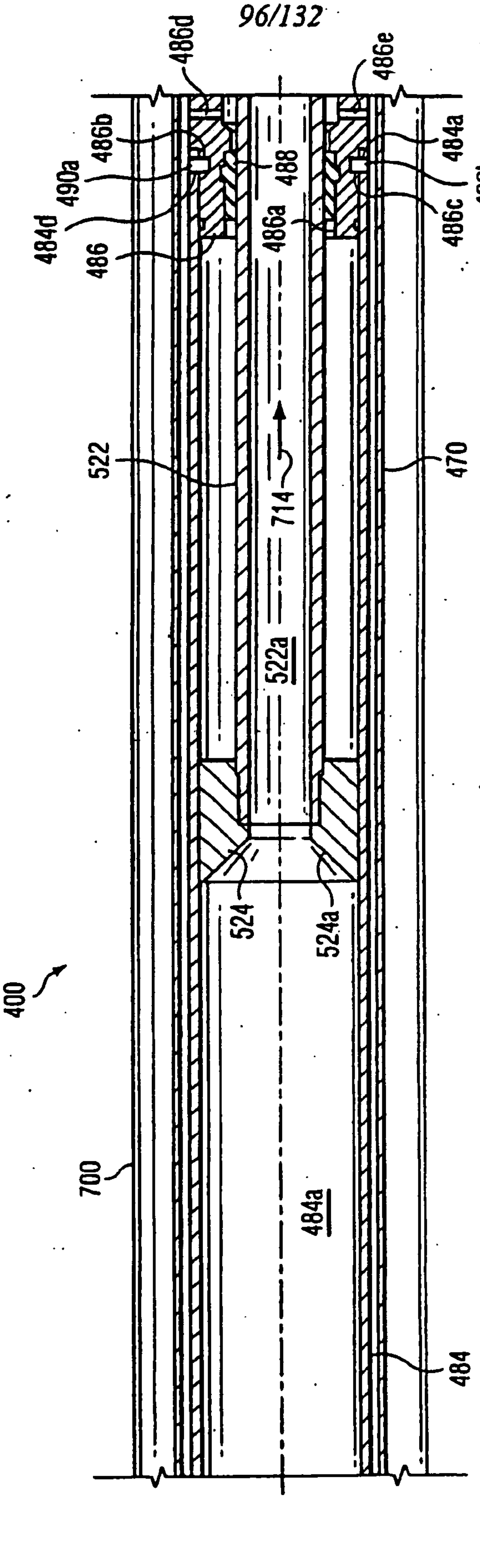
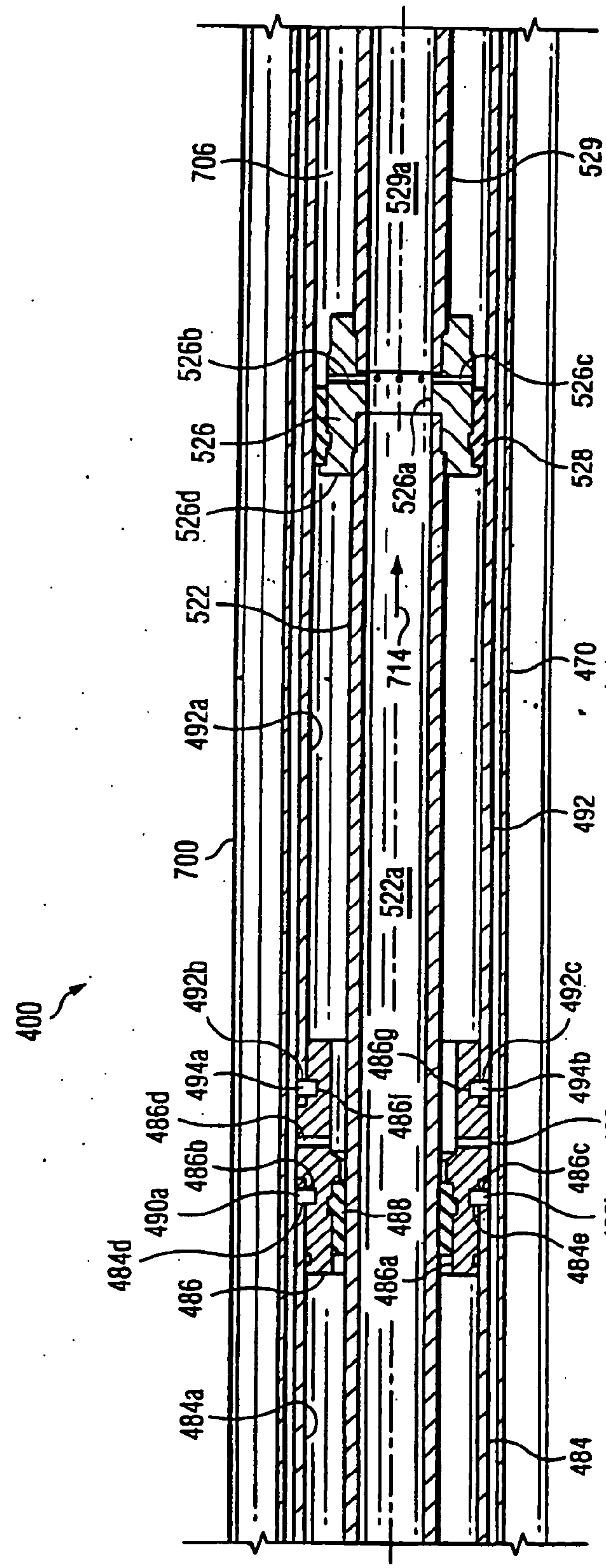

486d
486e
486b
484a
490a
488
490b
484d
486a
486c
486
522
714
470
522a
524
524a
400
700
484a
484

Fig. 33f



706
529a
529
526b
526c
526
528
526d
526a
522
714
470
492a
700
492
522a
400
492b
492c
486g
494a
494b
486d
486f
486e
486b
486c
490a
488
490b
484d
484e
486
486a
484a
484

Fig. 33g

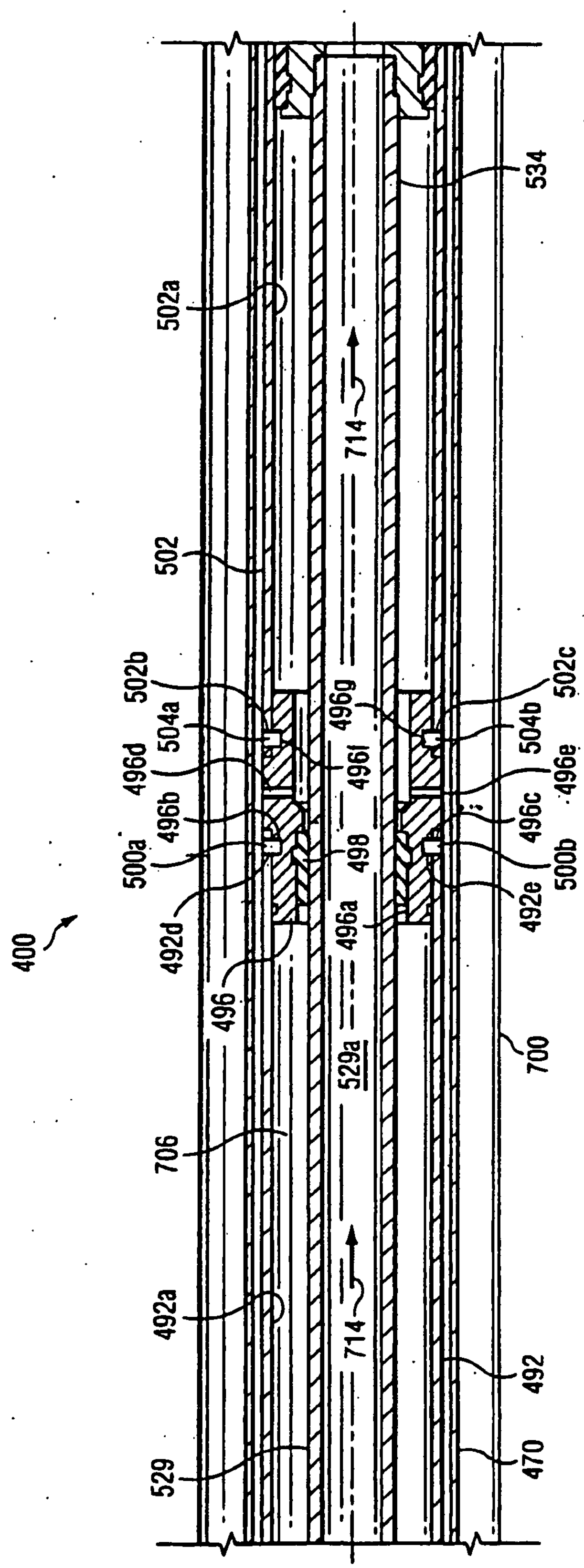
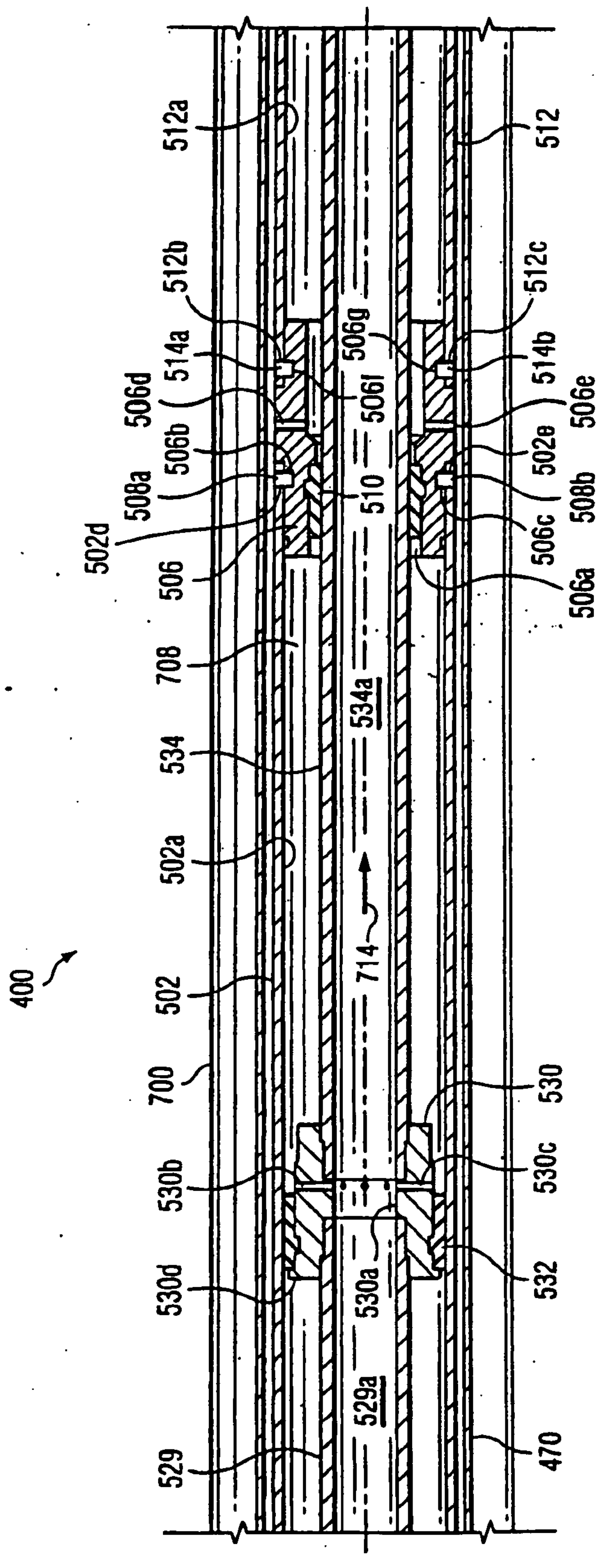
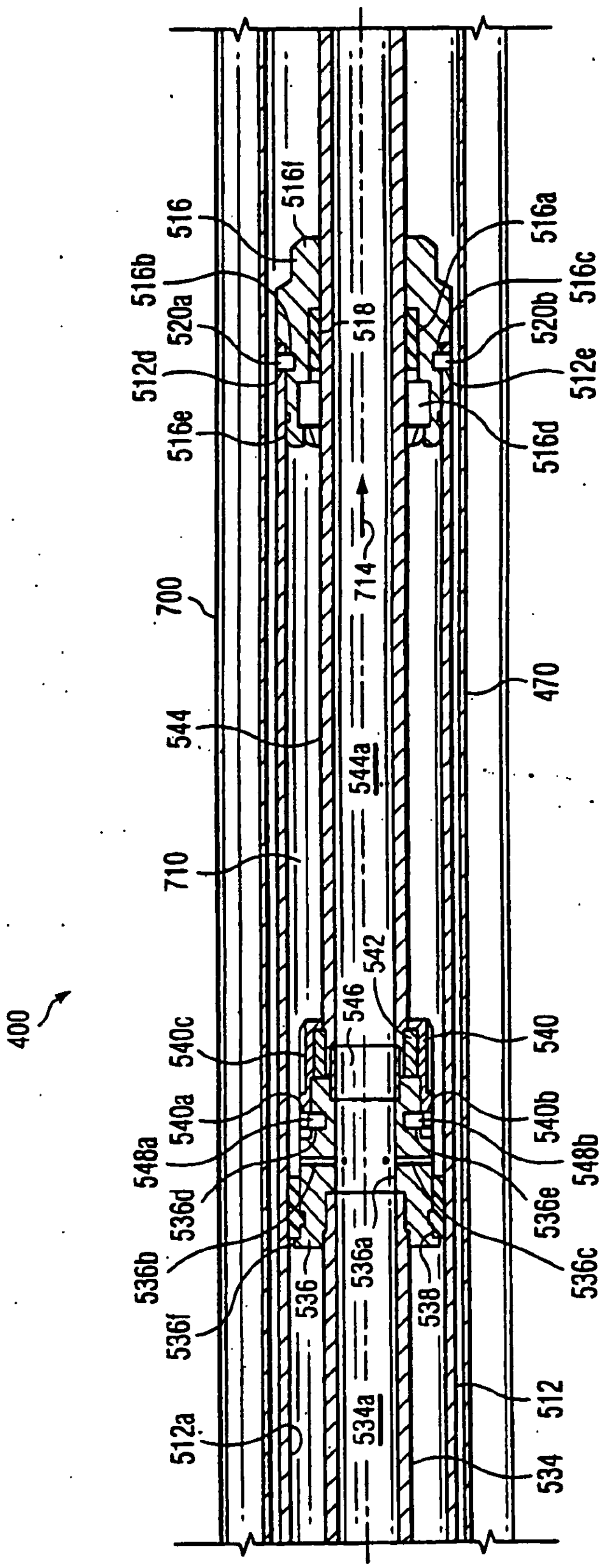

400
502a
502
502b
504a
496d
496b
500a
492d
496
706
492a
529
714
714
529a
496g
496f
498
496a
534
502c
504b
496e
496c
500b
492e
700
492
470

Fig. 33h



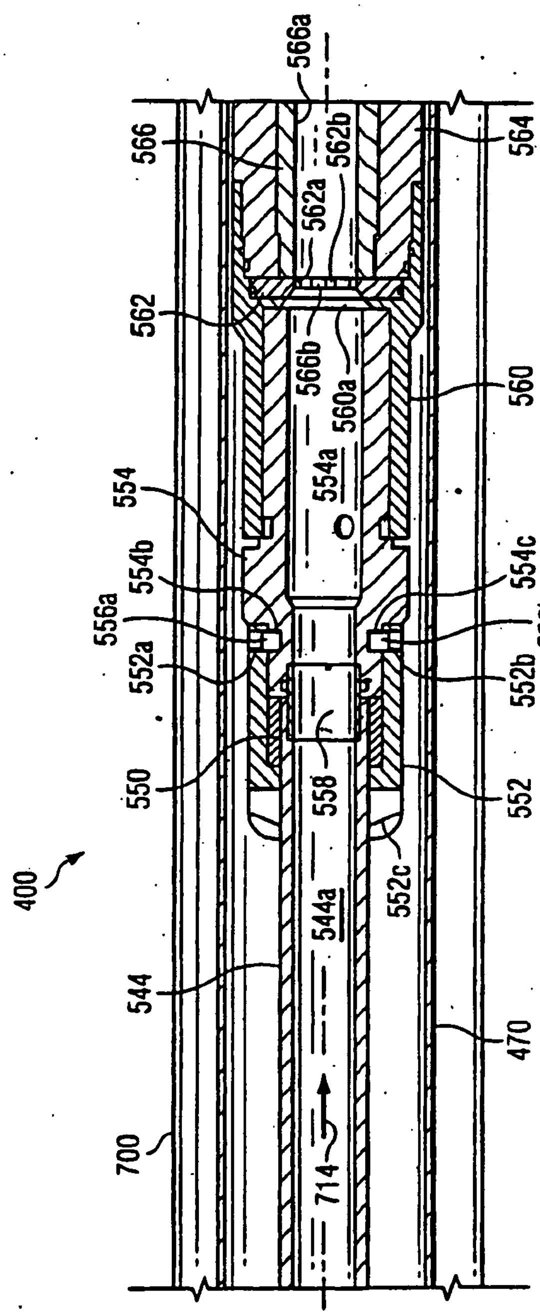
512a
512
512b
512c
514a
514b
506g
506d
506l
506e
506b
502e
508a
510
508b
502d
506
506c
506a
708
534a
534
502a
714
400
502
700
530
530c
530b
532
530d
530a
529a
529
470

Fig. 33i



516
516f
516b
520a
512d
516e
518
516a
516c
520b
512e
516d
700
714
544
544a
470
710
400
540c
546
542
540
540a
540b
548a
548b
536d
536e
536b
536f
536
536a
538
536c
512a
534a
512
534

Fig. 33j



566a
566
562b
562a
564
562
566b
560a
560
554a
554
554b
554c
556a
556b
552a
552b
550
558
552
400
552c
544a
544
470
700
714

Fig. 33k

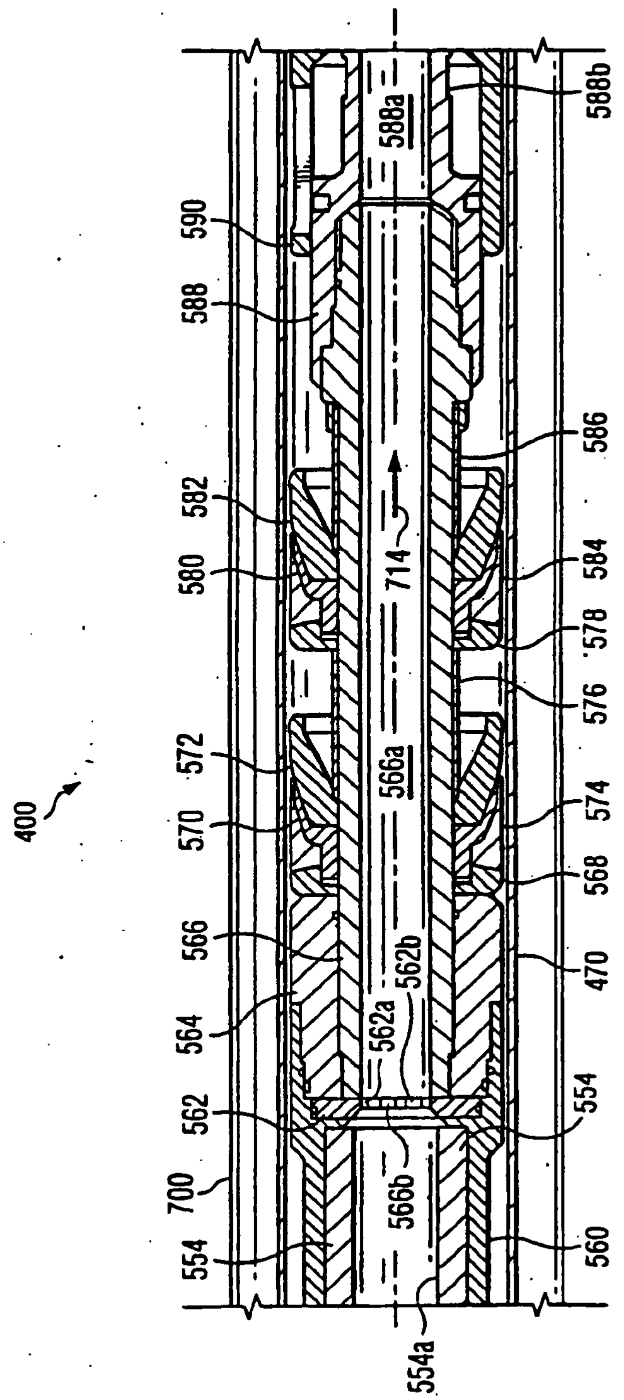
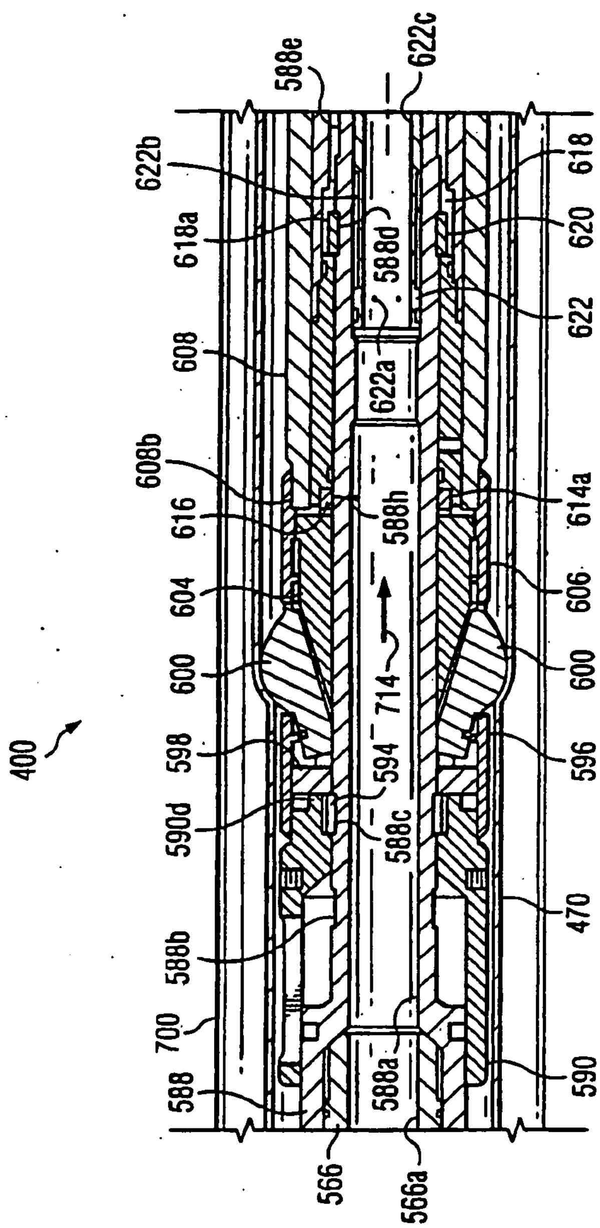

400
590
588
582
580
572
570
566
564
562
700
554
588b
588a
586
584
578
576
574
568
470
554
560
714
566a
562a
562b
566b
554a

Fig. 331



588e
622c
622b
618
618a
588d
620
622
608
622a
608b
614a
616
588h
604
606
600
714
600
400
598
594
596
590d
588c
588b
470
700
588
588a
590
566
566a

Fig. 33m

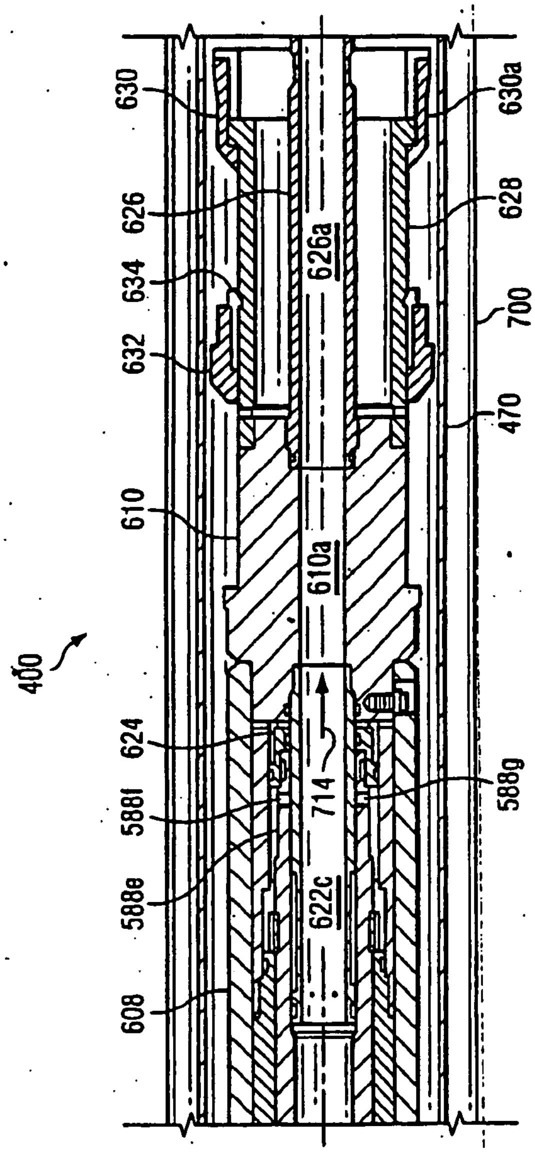

400
630
626
634
632
610
624
588f
588e
608
626a
610a
714
622c
630a
628
700
470
588g

Fig. 33n

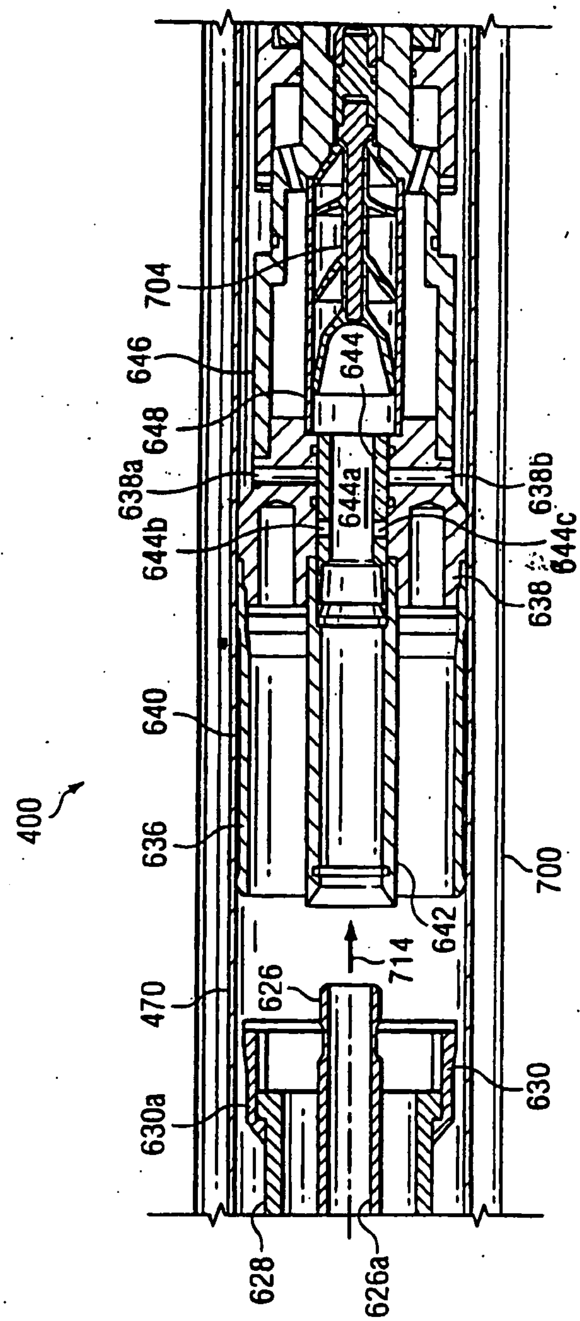

400
704
646
648
638a
644b
640
636
470
626
714
642
644
644a
638b
644c
638
700
630
630a
628
626a

Fig. 33o

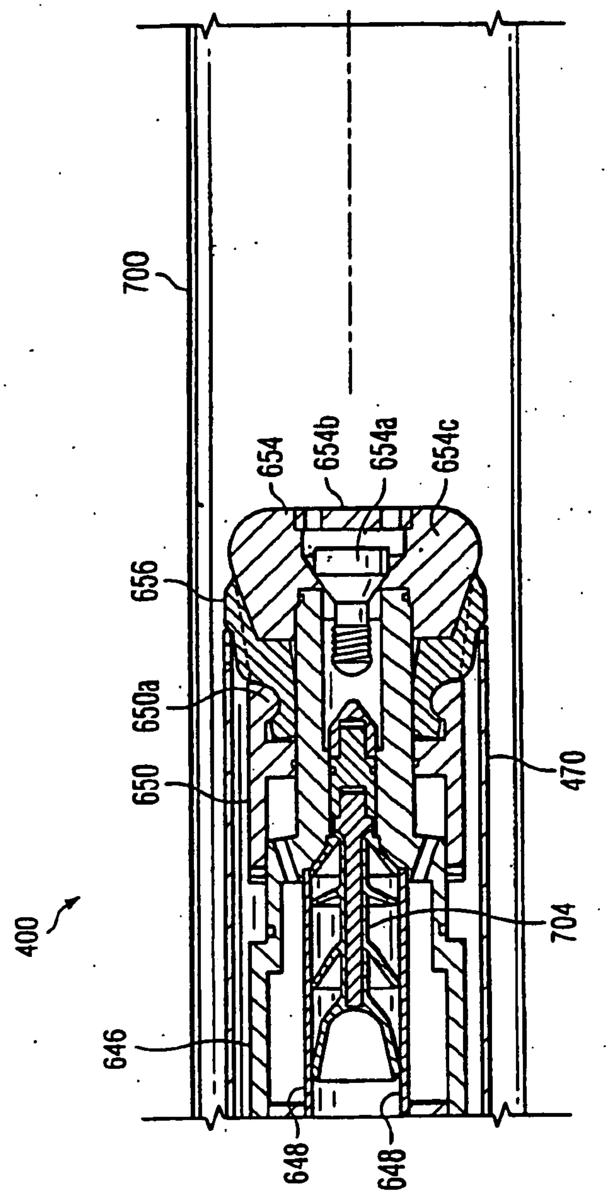
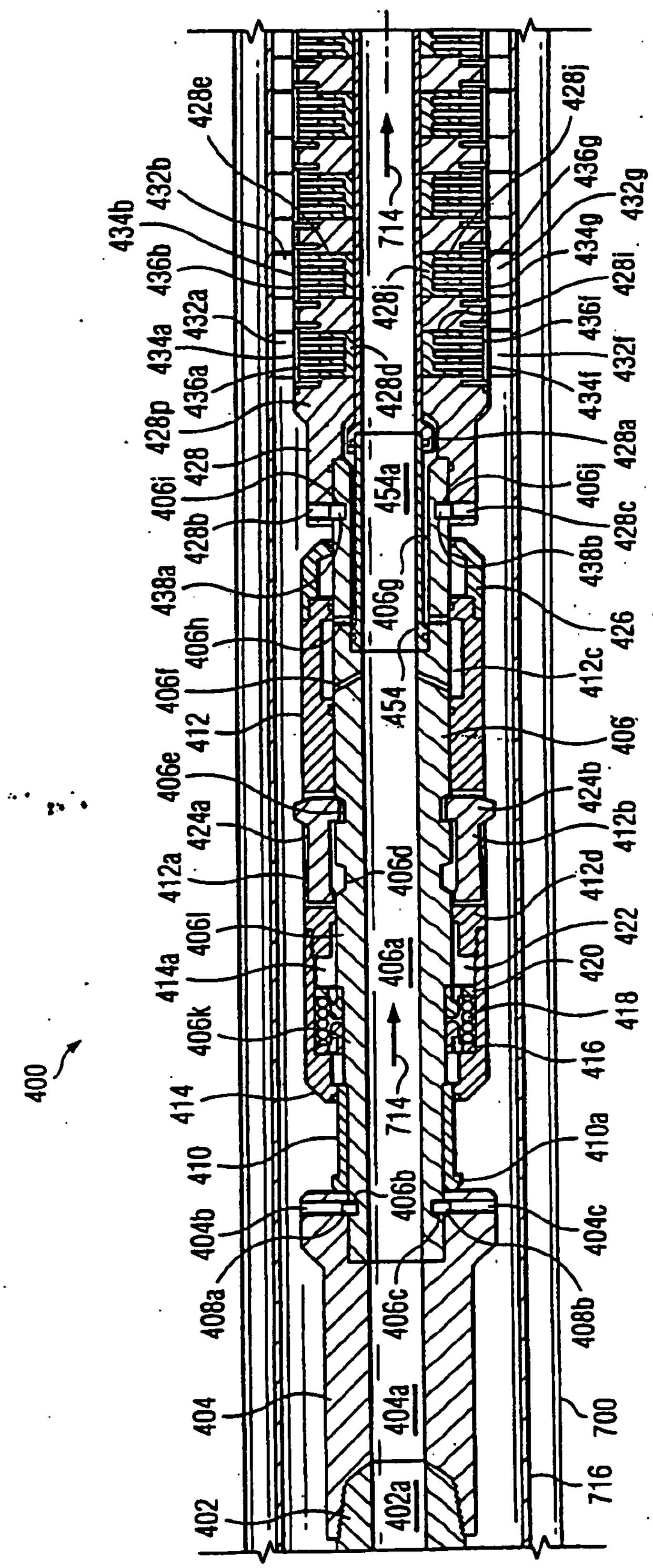


Fig. 33p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402
402a
404
404a
404b
404c
406
406a
406b
406c
406d
406e
406f
406g
406h
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406j
406k
406l
408a
408b
410
410a
412
412a
412b
412c
412d
414
414a
416
418
420
422
424a
424b
426
428
428a
428b
428c
428d
428e
428i
428j
428p
432a
432b
432f
432g
434a
434b
434f
434g
436a
436b
436g
436i
438a
438b
454
454a
700
714
716

Fig. 34a

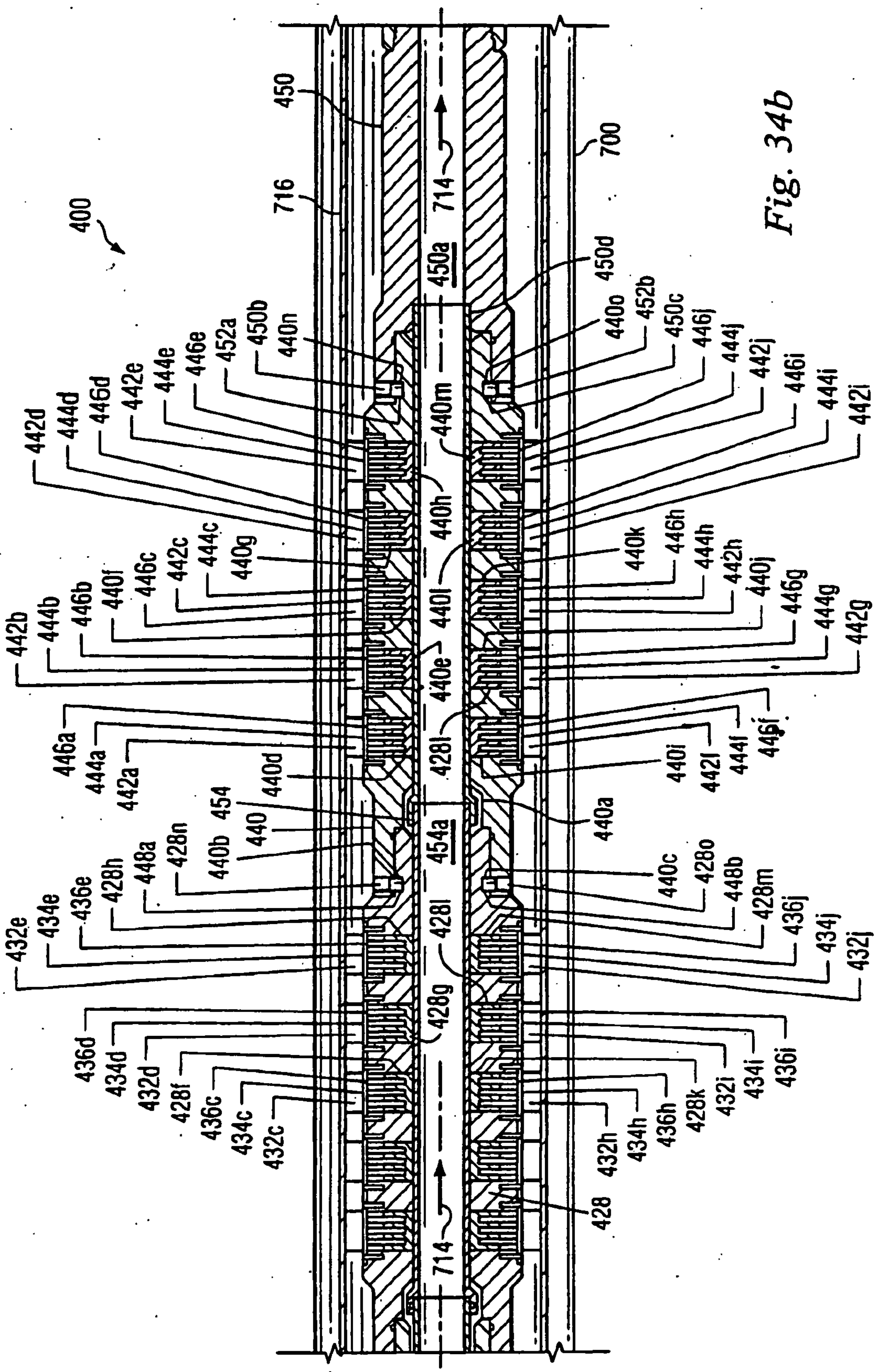

400
716
450
714
700
450a
450d
450b
440n
452a
446e
444e
442e
446d
444d
442d
440o
452b
450c
446j
444j
442j
446i
444i
442i
440m
440h
440g
444c
442c
446c
440f
446b
444b
442b
440k
446h
444h
442h
440j
446g
444g
442g
440l
440e
428l
446a
444a
442a
440d
454
440
440b
428n
448a
428h
436e
434e
432e
440i
442l
444f
446f
440a
454a
440c
428o
448b
428m
436j
434j
432j
428g
436d
434d
432d
428f
436c
434c
432c
436i
434i
432i
428k
436h
434h
432h
428

Fig. 34b

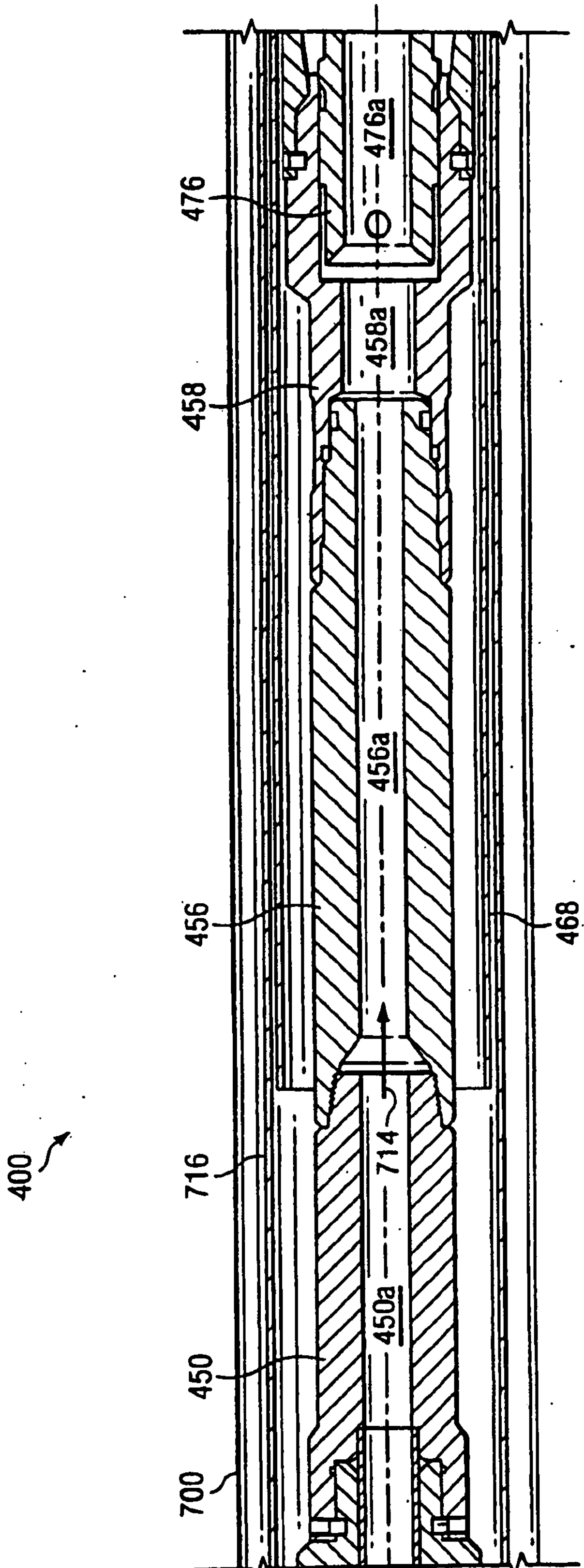


Fig. 34c

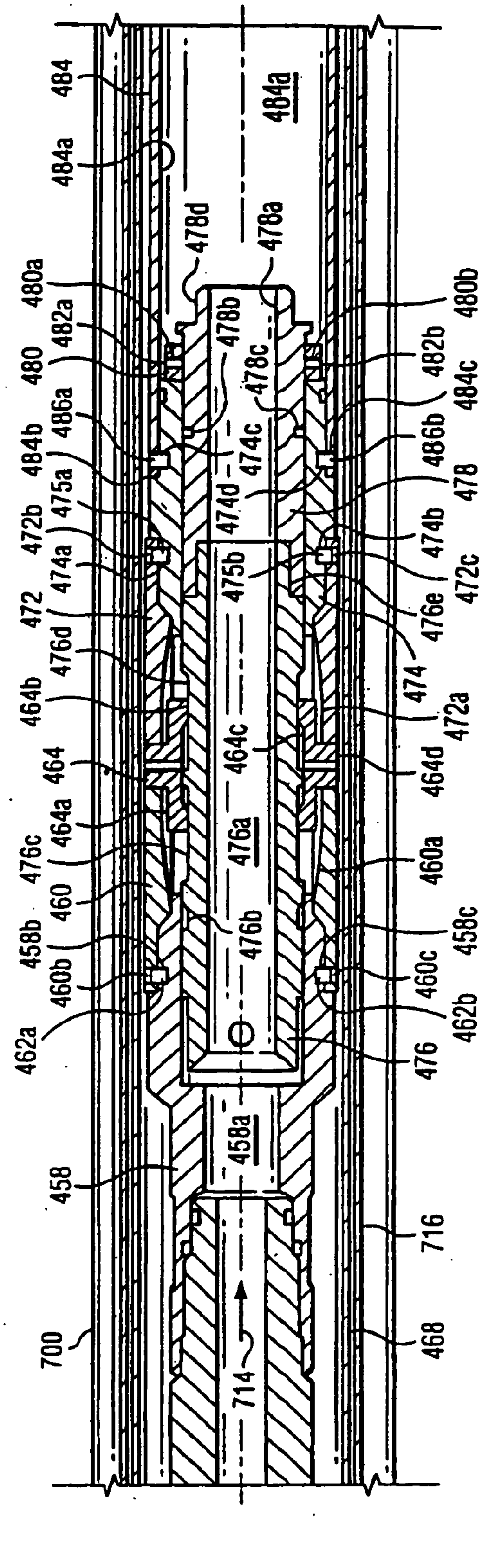
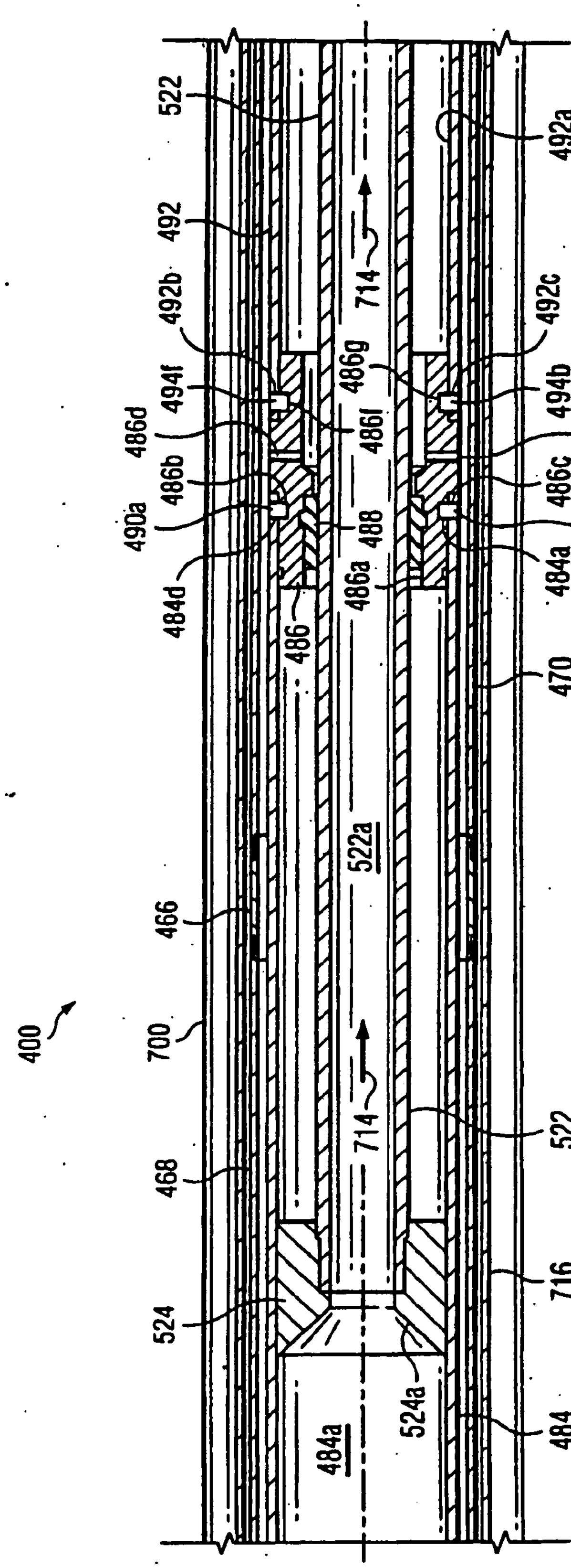

400
484
484a
484a
478d
478a
480a
482a
480
486a
484b
475a
472b
474a
472
476d
464b
464
464a
476c
460
458b
460b
462a
458
700
714
458a
476a
476b
464c
475b
474d
474c
478c
478b
480b
482b
484c
486b
478
474b
472c
476e
474
472a
464d
460a
458c
460c
462b
476
716
468

Fig. 34d



522
492
492b
494f
486d
486b
490a
484d
486
466
400
700
468
524
484a
524a
714
714
486a
488
486l
486g
522a
492a
492c
494b
486e
486c
490b
484a
470
522
716
484

Fig. 34e

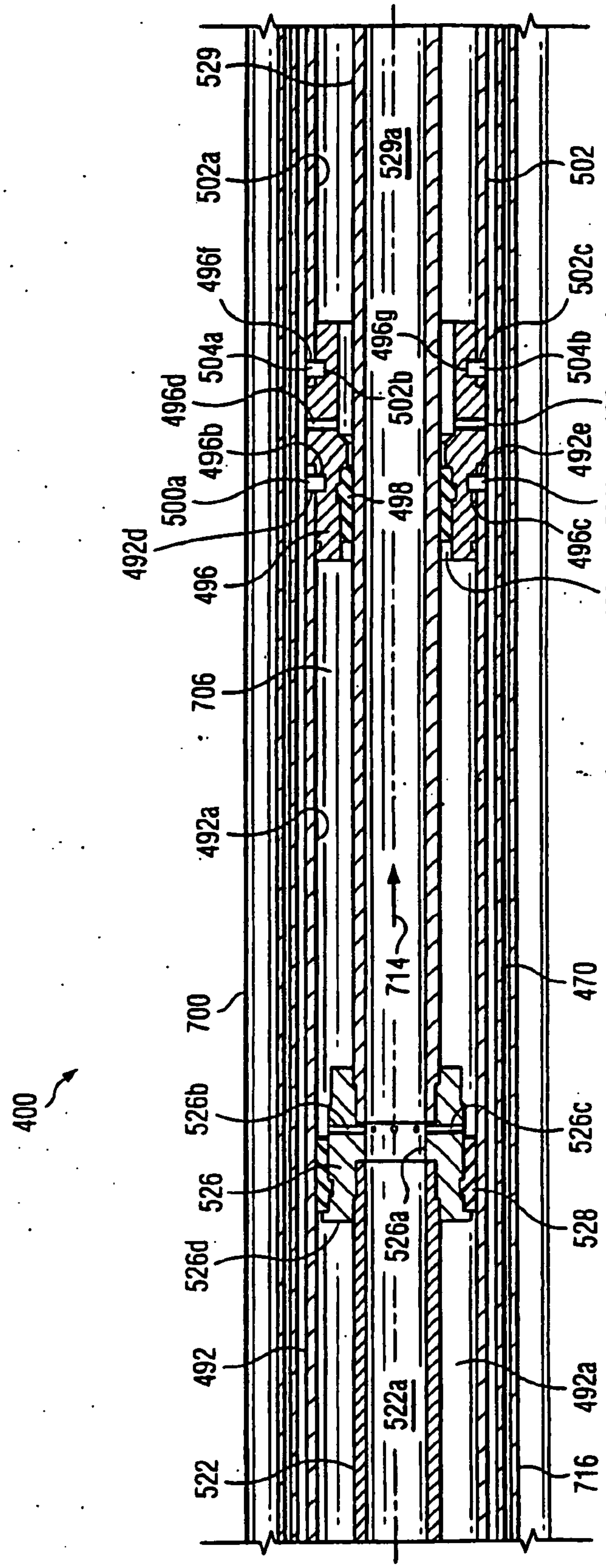

529
529a
502a
502
496f
502c
496g
504a
504b
496d
502b
496e
496b
492e
500a
498
500b
492d
496c
496
496a
706
492a
714
700
470
400
526b
526c
526
526a
528
526d
492
522a
492a
522
716

Fig. 34f

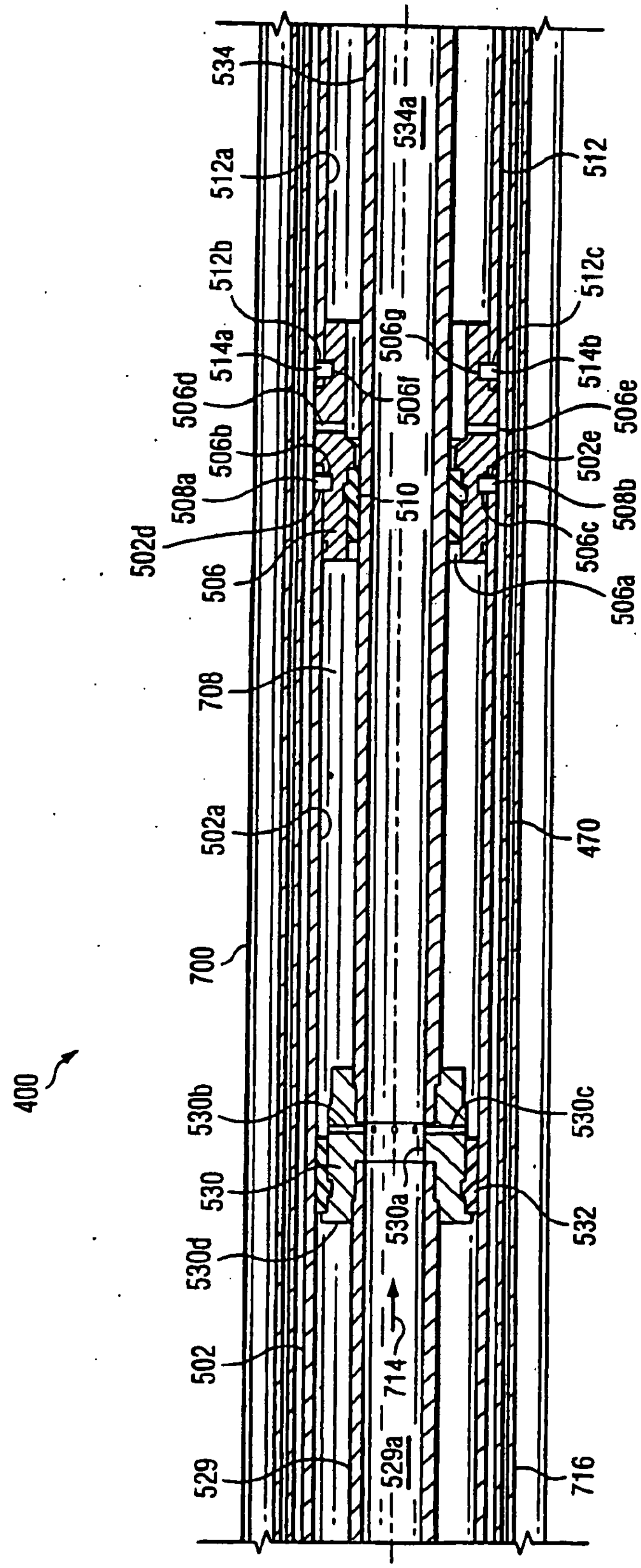
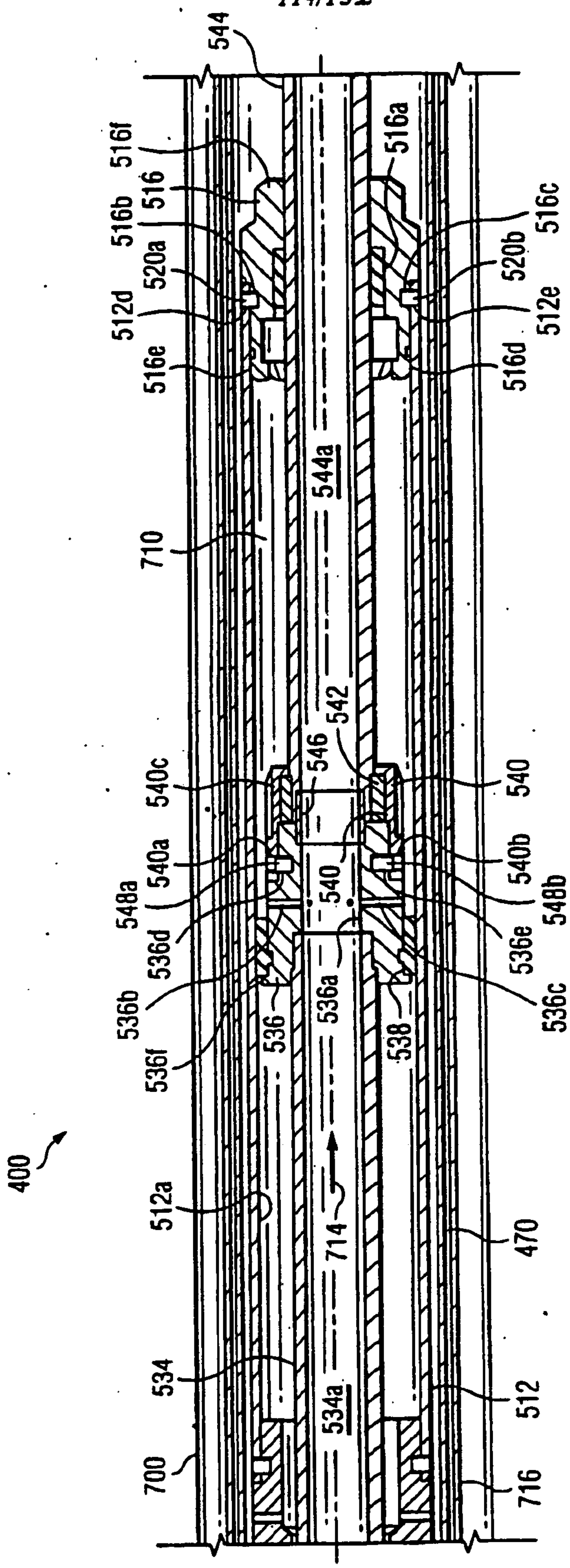

534
534a
512
512a
512b
512c
506g
514a
514b
506f
506d
506e
506b
502e
508a
508b
510
502d
506c
506
506a
708
502a
470
700
400
530b
530c
530
532
530a
530d
502
714
529
529a
716

Fig. 34g



544
516f
516
516b
520a
512d
516e
516a
516c
520b
512e
516d
544a
710
542
546
540c
540a
548a
536d
536b
536f
540
540b
548b
536e
536c
536a
536
538
400
512a
714
470
534
534a
512
700
716

Fig. 34h

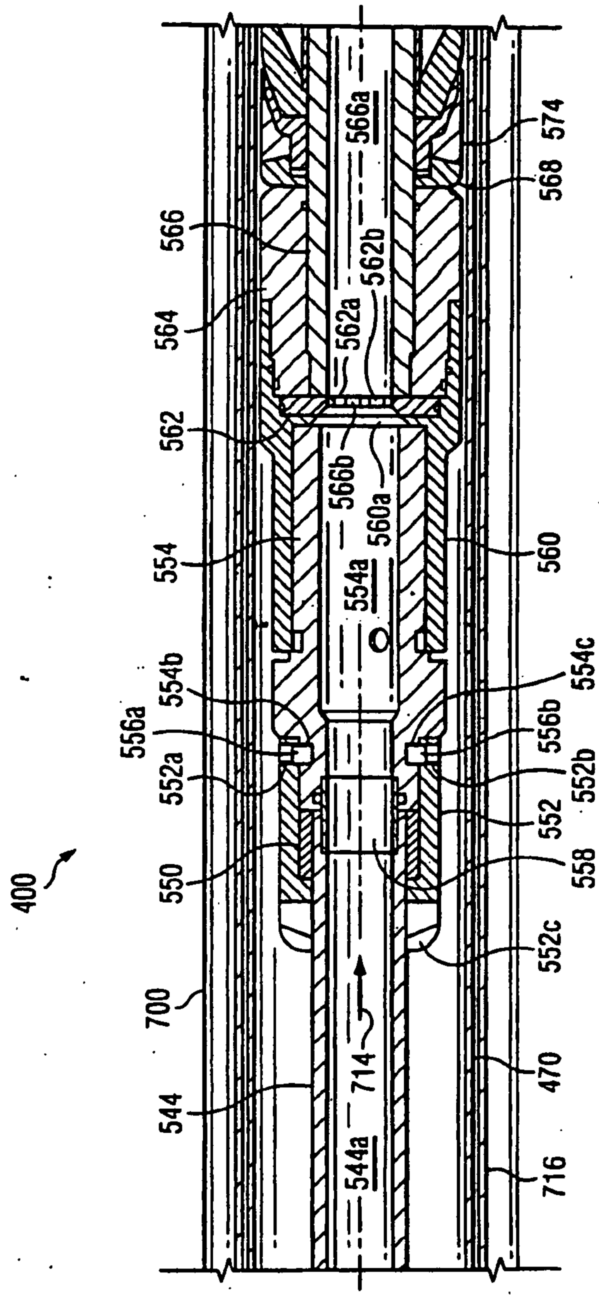

400
566a
574
568
566
562b
562a
564
562
566b
560a
554
560
554a
554c
554b
556a
556b
552a
552b
552
558
550
552c
700
714
544
470
544a
716

Fig. 34i

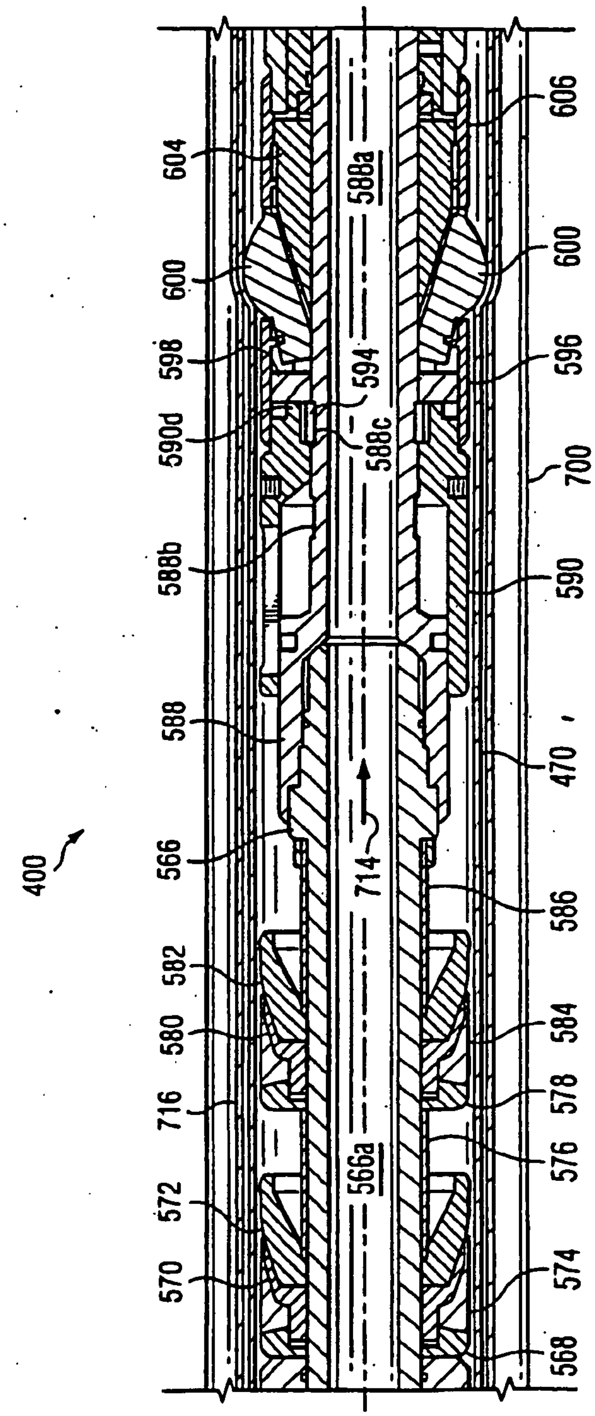
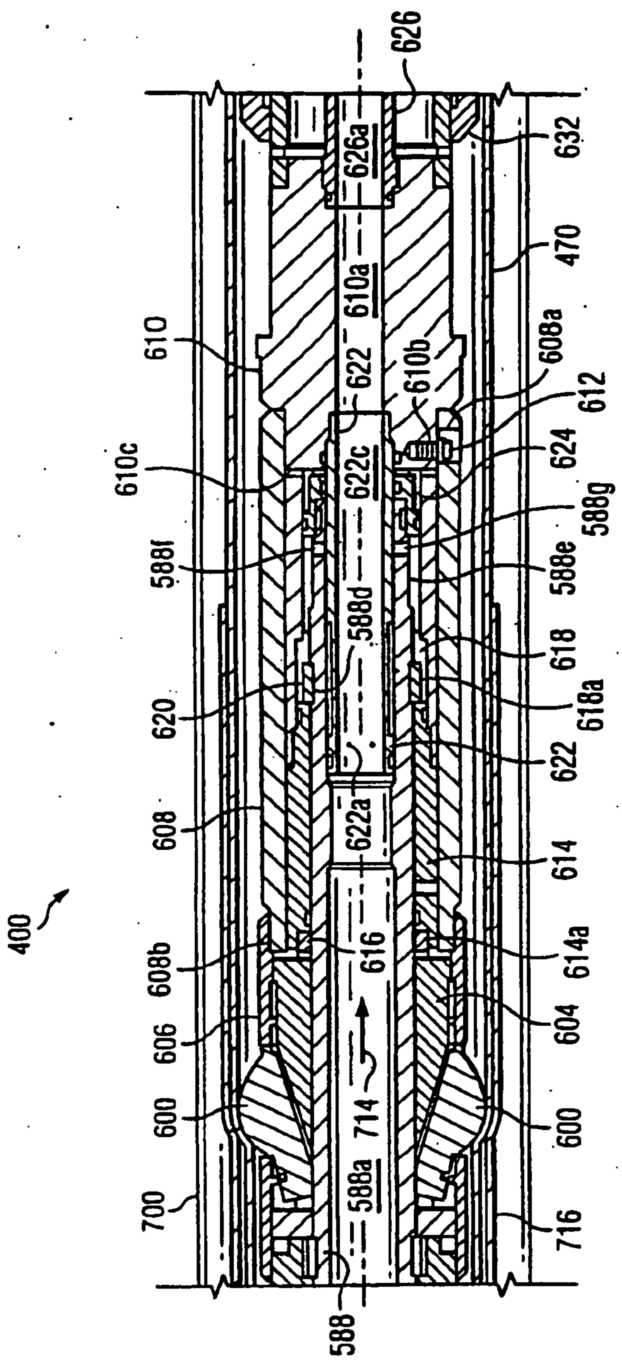

400
604
600
598
590d
588b
588
566
582
580
716
572
570
606
600
596
700
590
470
586
584
578
576
574
568
594
588c
588a
714
566a

Fig. 34j



626
632
626a
470
610
610a
622
608a
610b
612
610c
622c
624
588g
588f
588e
588d
618
620
618a
622
608
622a
614
400
616
614a
608b
606
604
600
714
600
700
588a
716
588

Fig. 34k

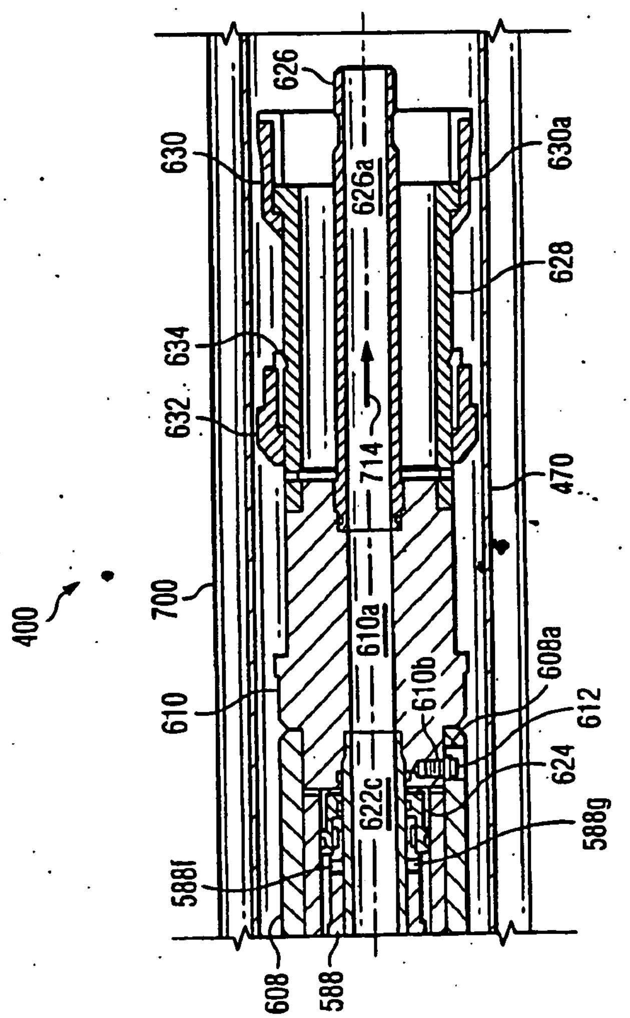

400
700
610
632
634
630
626
626a
714
610a
610b
622c
588f
608
588
630a
628
470
608a
612
624
588g

Fig. 34l

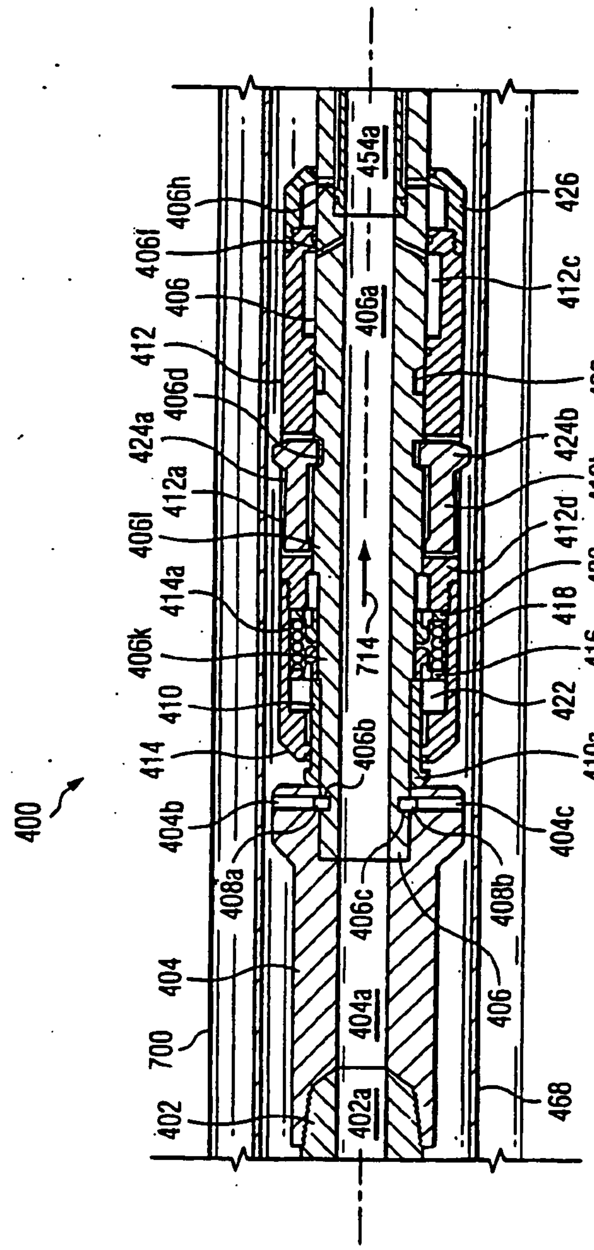
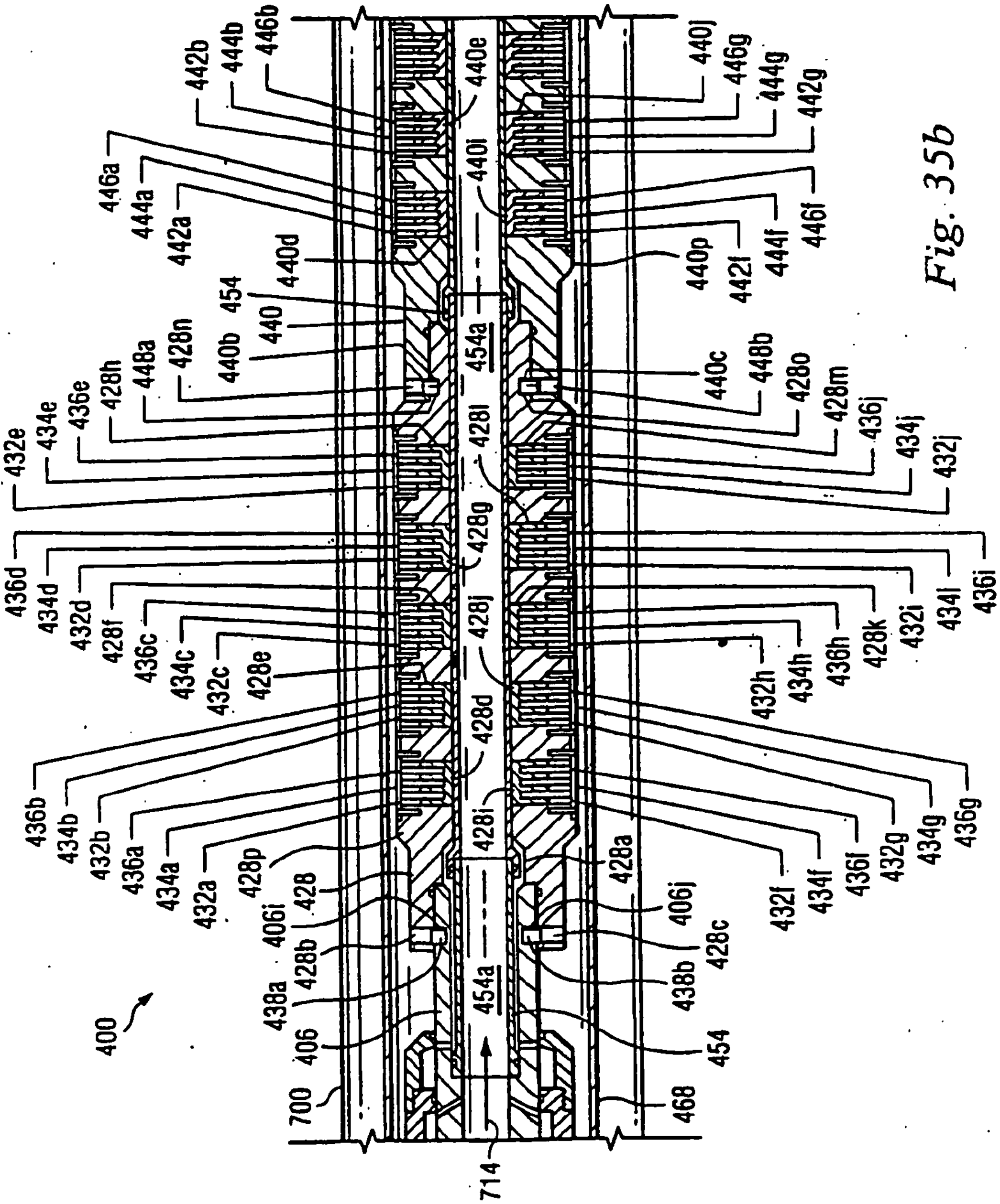

400
402
402a
404
404a
404b
404c
406
406a
406b
406c
406d
406e
406h
406i
406k
406l
408a
408b
410
410a
412
412a
412b
412c
412d
414
414a
416
418
420
422
424a
424b
426
454a
468
700
714

Fig. 35a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428j
428d
428i
454a
714
468
454
438b
428c
406j
428a
432f
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432g
434g
436g
432h
434h
436h
428k
432i
434i
436i
432j
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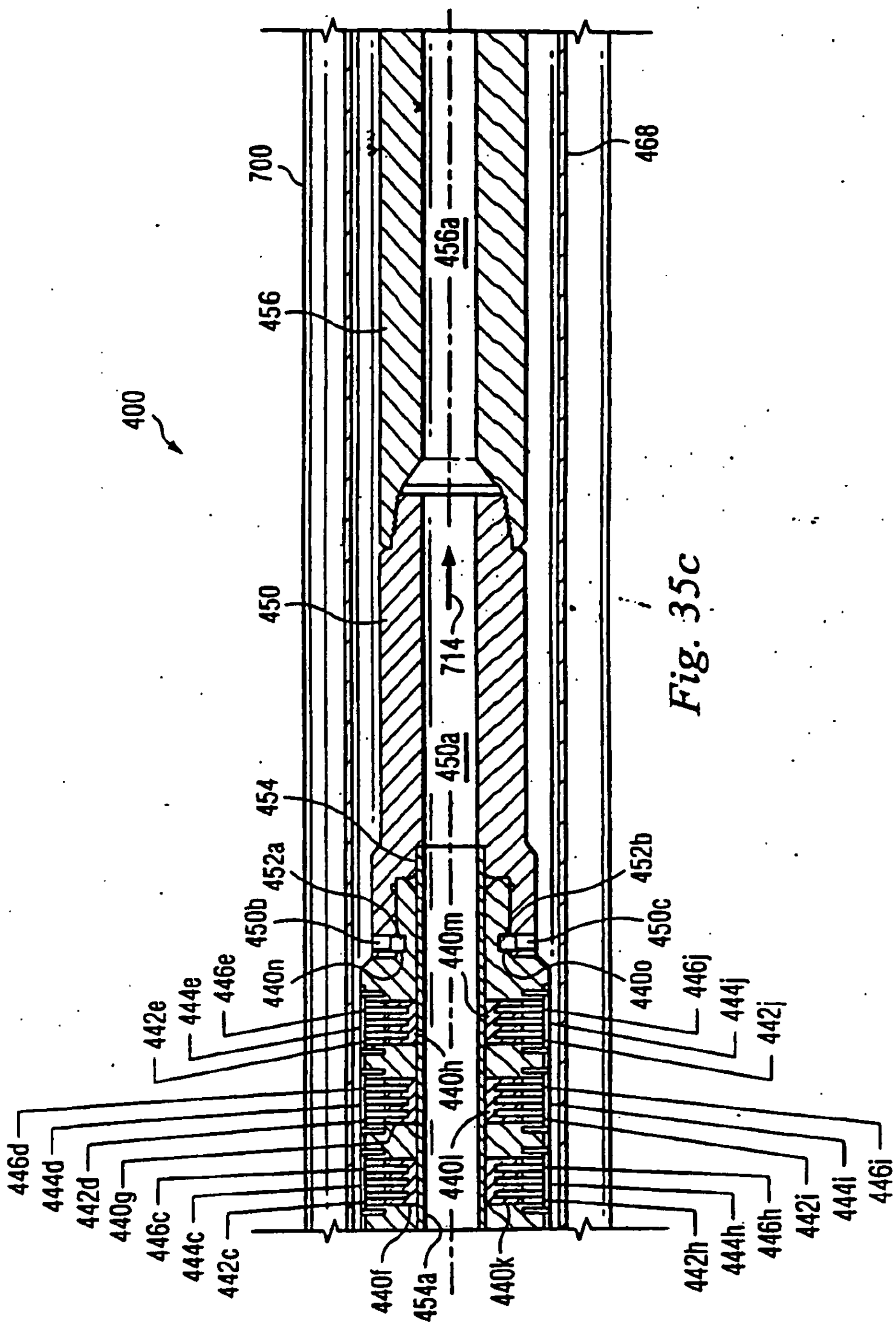
440j

Fig. 35b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442i
444i
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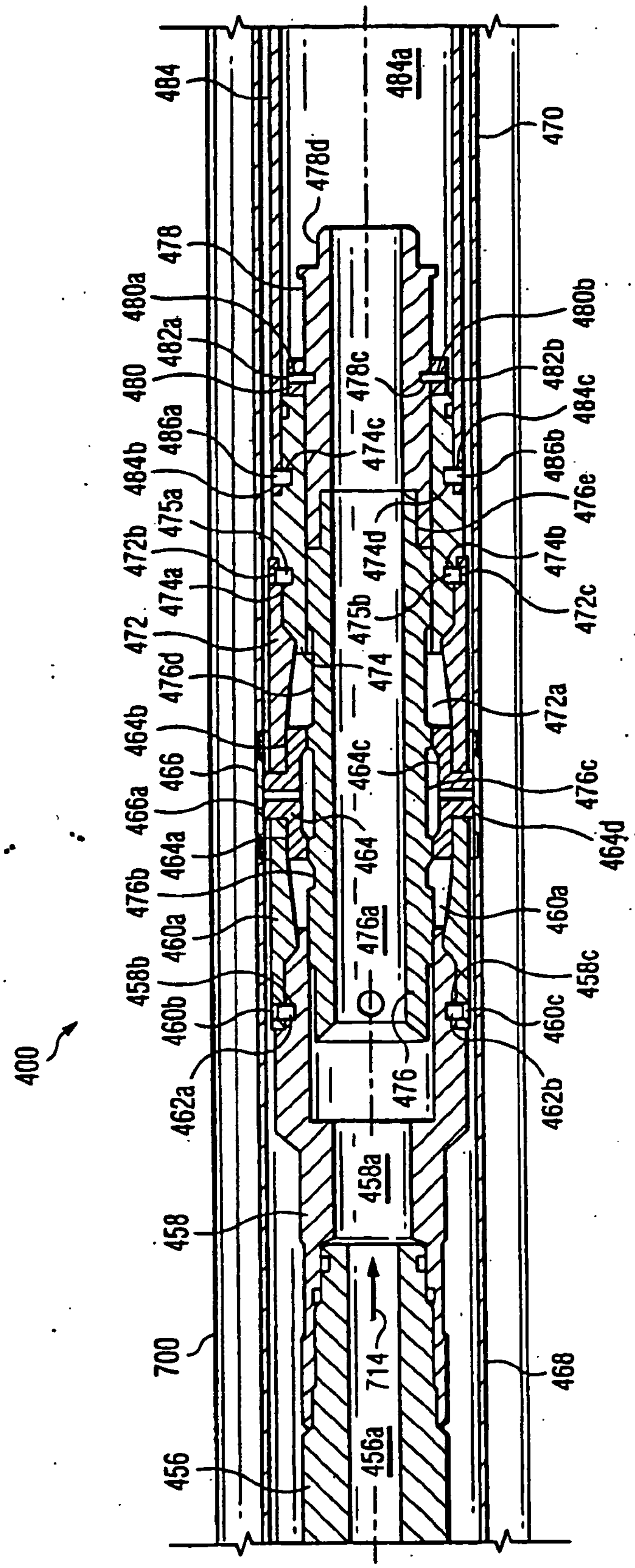
440h
440l

Fig. 35c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472b
474b
474a
475b
472c
472
474
476d
472a
464b
464c
466
476c
466a
464
464d
464a
476a
476b
460a
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460c
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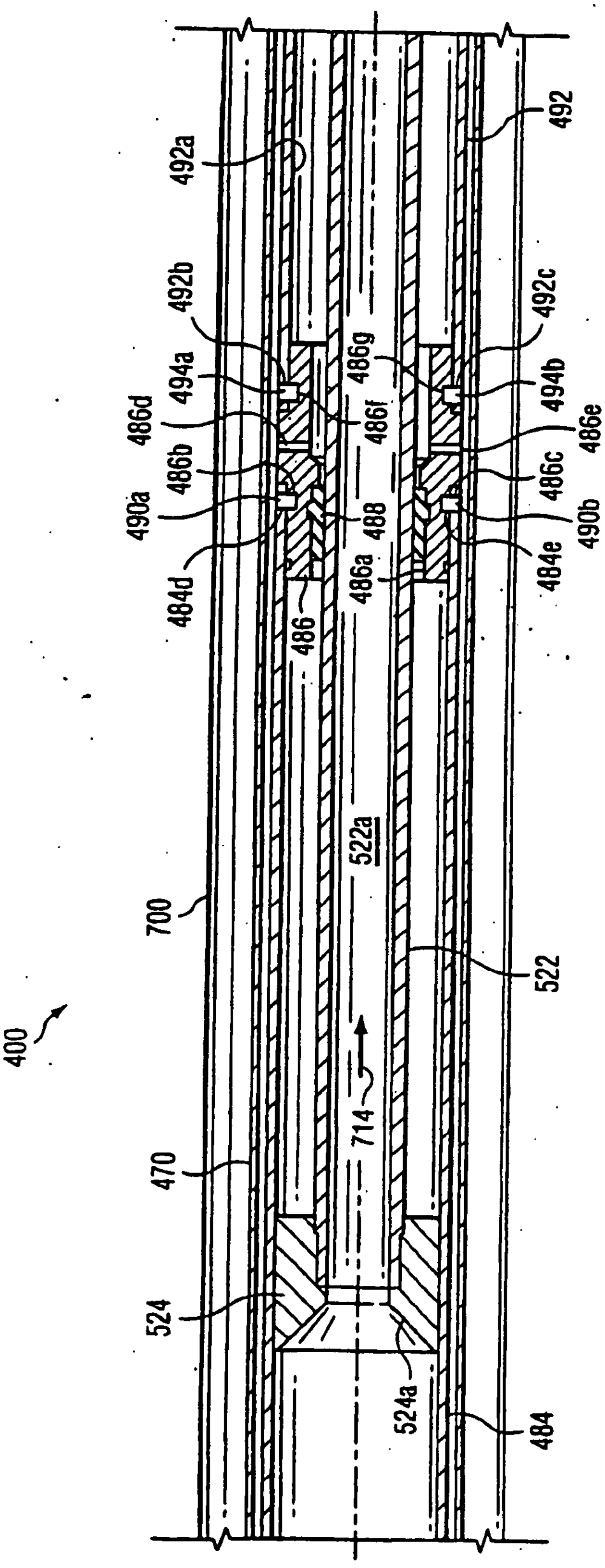
468
456a
456

Fig. 35d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522
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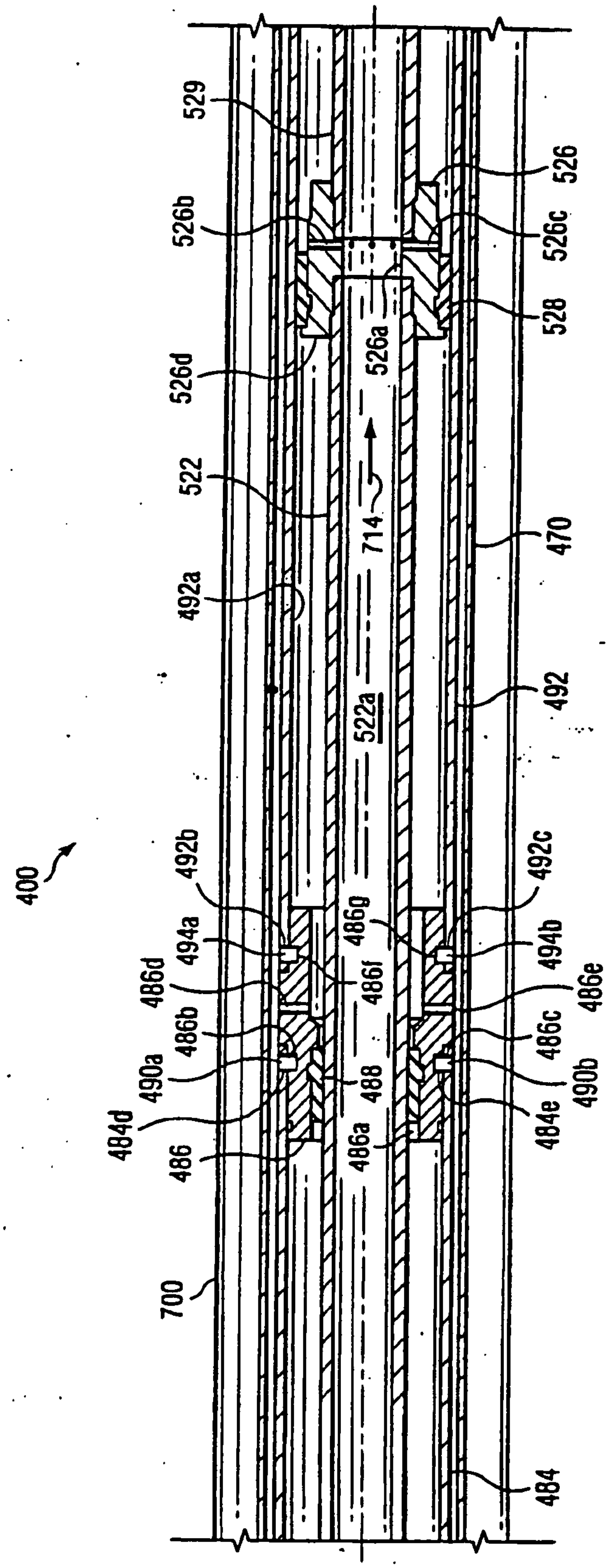
714
470
524
524a
484

Fig. 35e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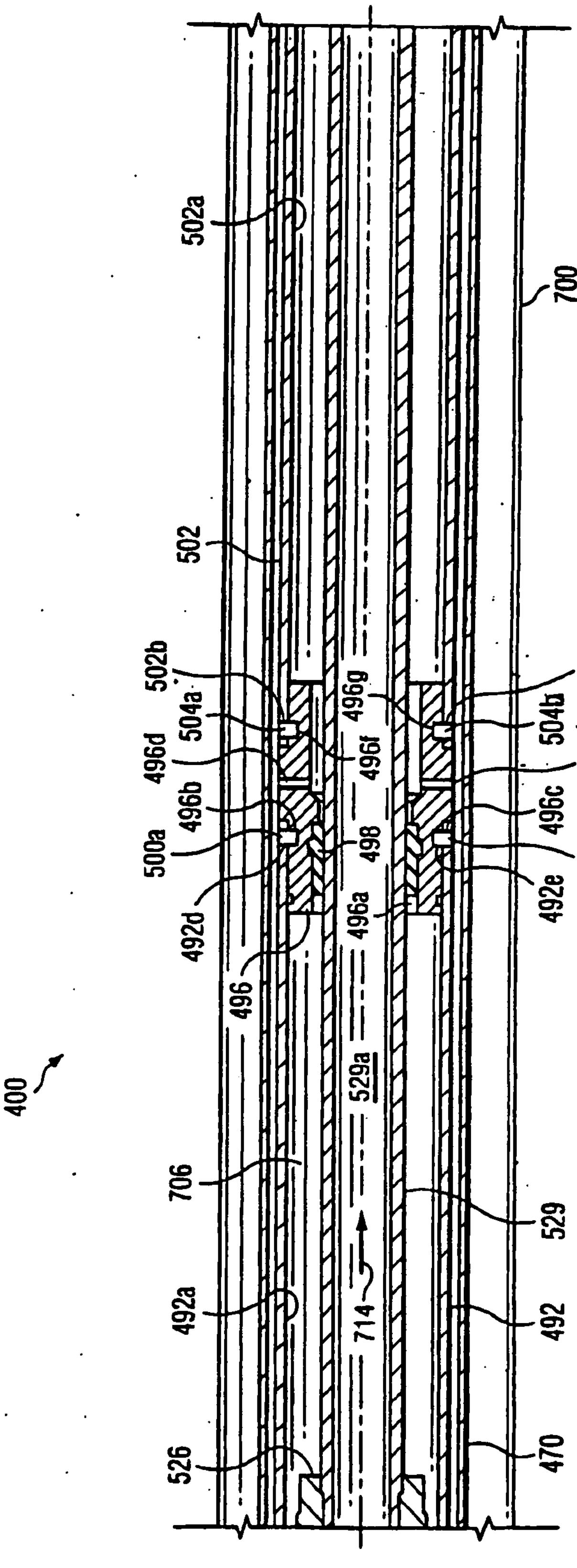
486a
700
484

Fig. 35f



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496f
498
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500b
492e
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492a
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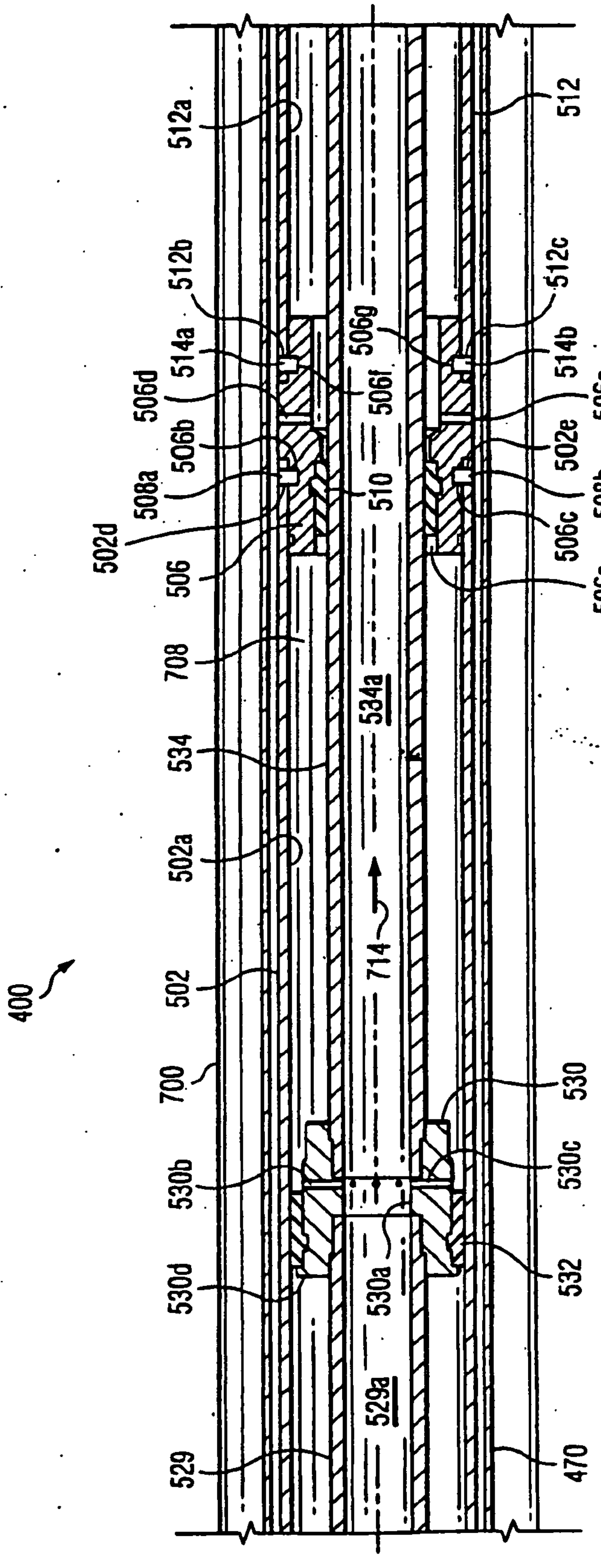
529
492
470

Fig. 35g



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534a
714
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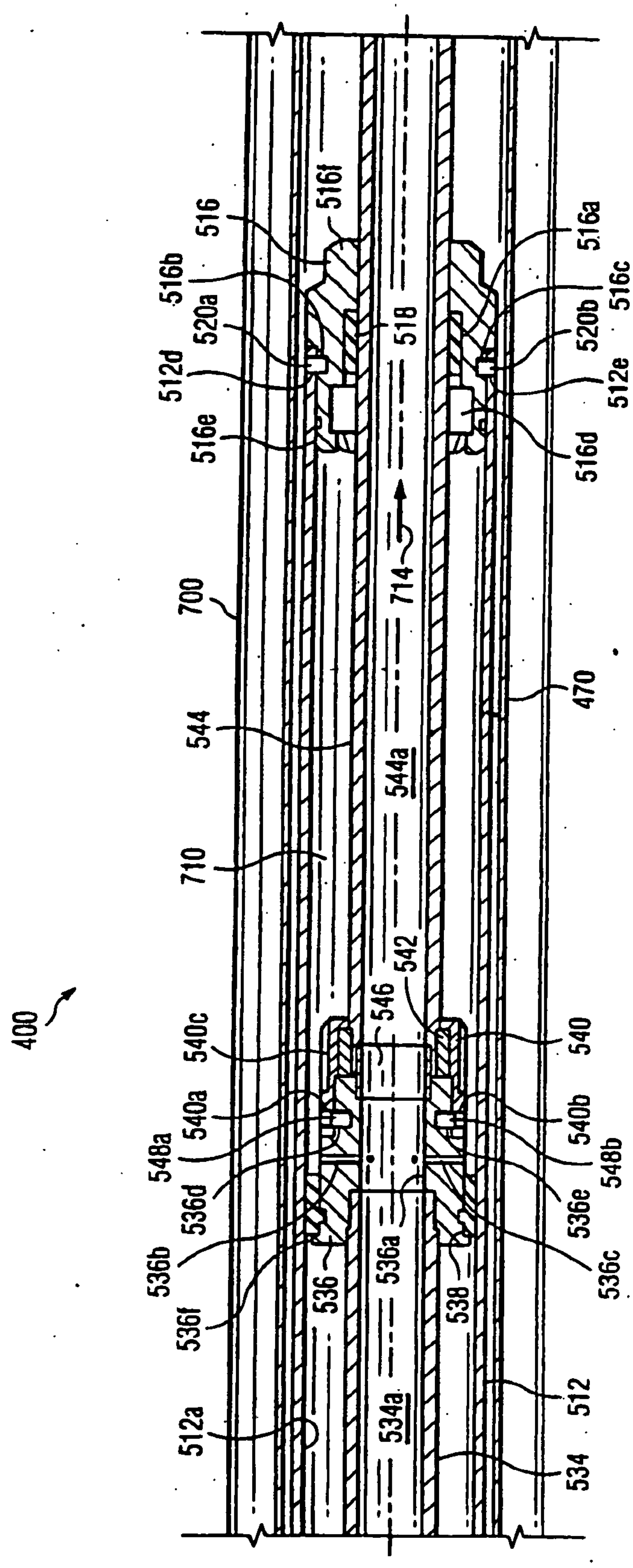
530c
532
470

Fig. 35h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540c
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548a
536d
536b
536f
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540b
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536e
536c
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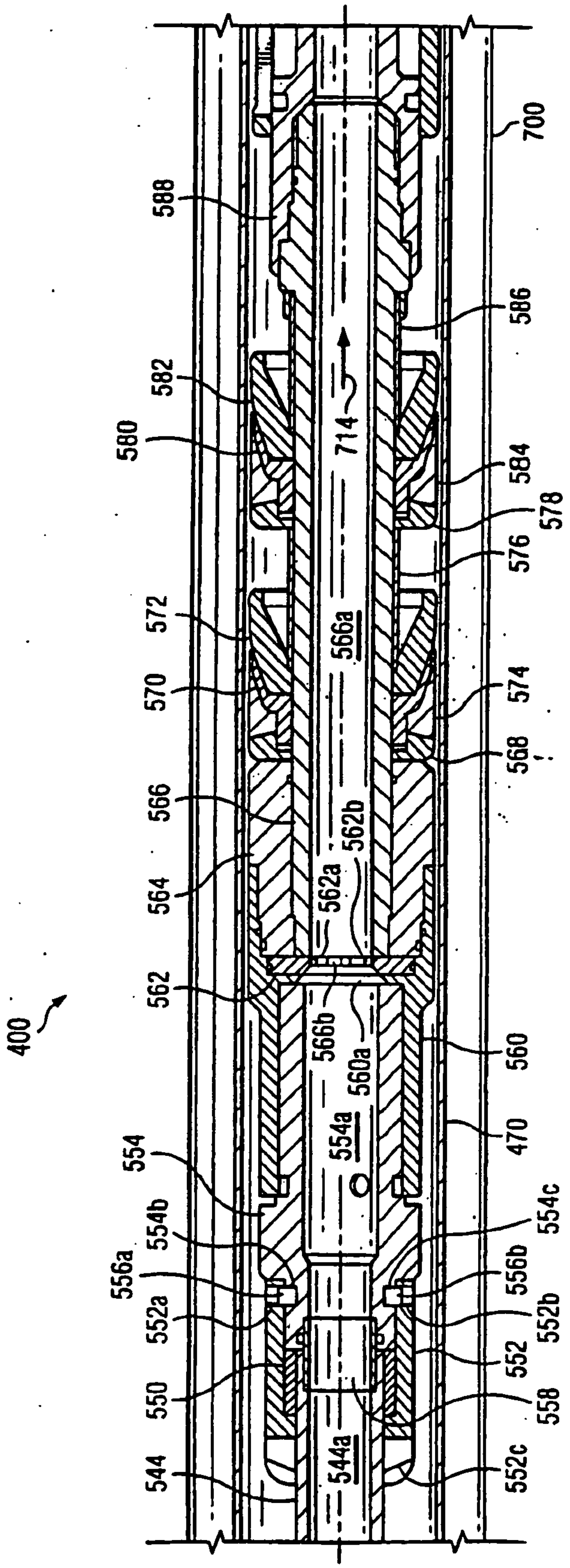
536a
538
512a
534a
512
534

Fig. 35i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560a
400
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556b
552b
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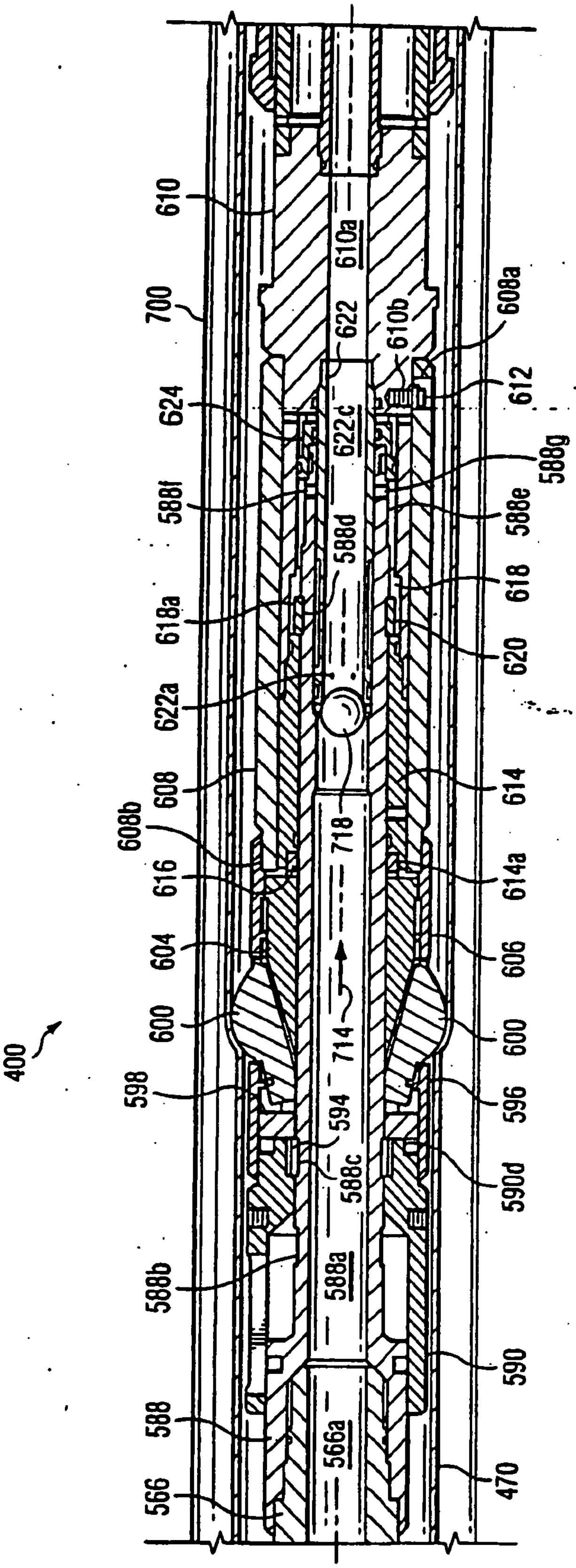
550
558
544
544a
552c

Fig. 35j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588d
718
714
594
588c
588a
566a
608a
610b
612
588g
588e
618
620
614
614a
606
600
596
590d
590
470

Fig. 35k

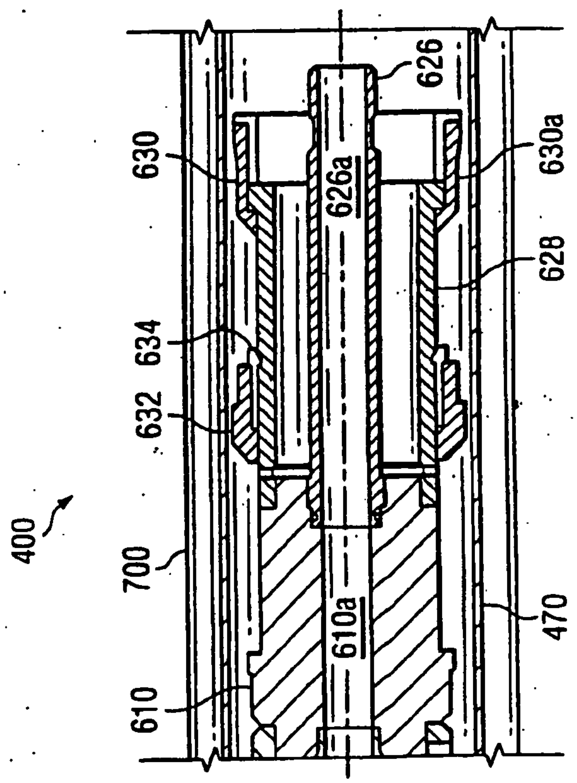
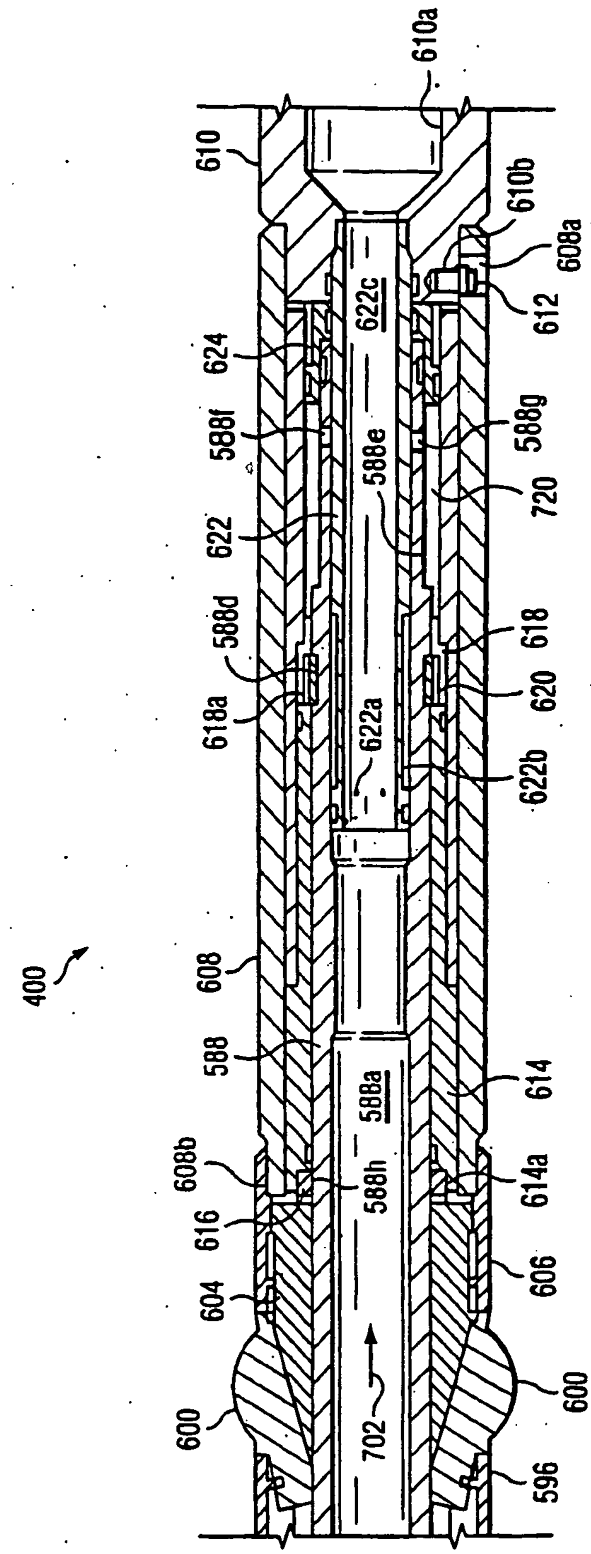


Fig. 35I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608b
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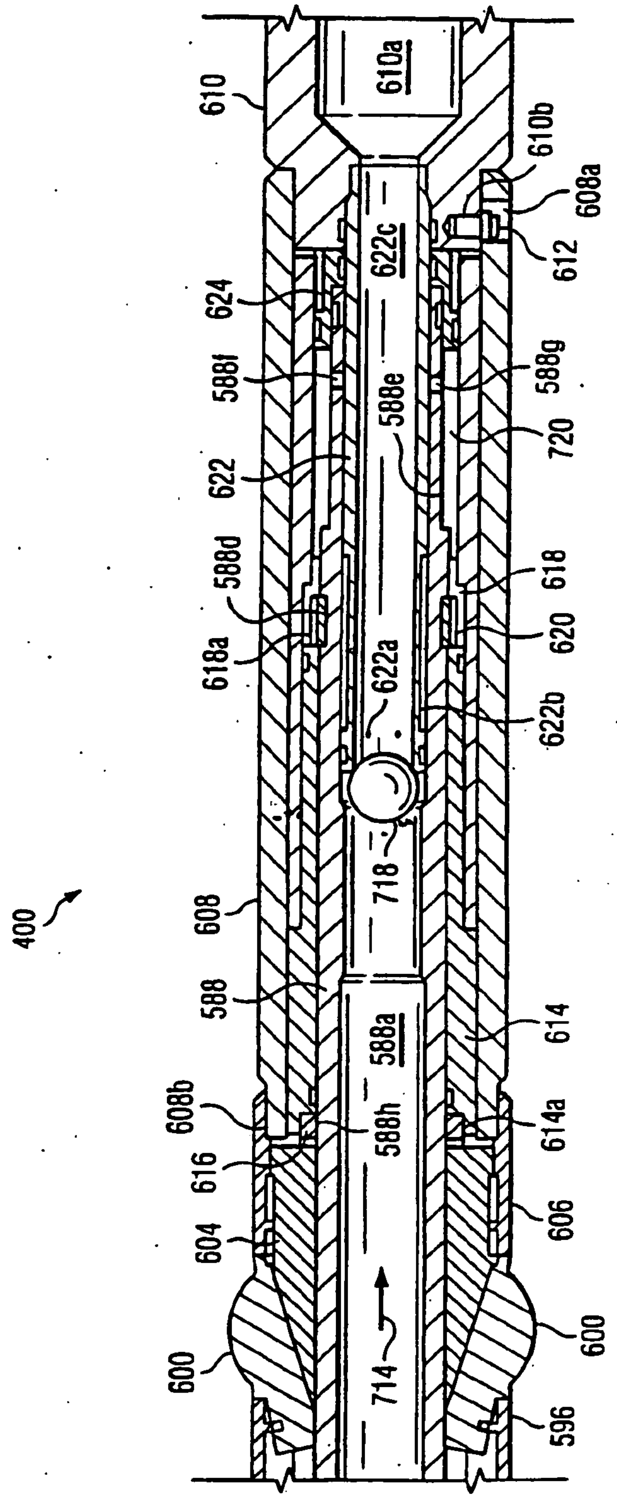
702
600
596

Fig. 36a



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608b
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606
600
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714
596

Fig. 36b

MONO DIAMETER WELLBORE CASING

This invention relates generally to oil and gas exploration, and in particular to a method for forming and repairing wellbore casings to facilitate oil and gas exploration.

Background of the Invention

Conventionally, when a wellbore is created, a number of casings are installed in the borehole to prevent collapse of the borehole wall and to prevent undesired outflow of drilling fluid into the formation or inflow of fluid from the formation into the borehole. The borehole is drilled in intervals whereby a casing which is to be installed in a lower borehole interval is lowered through a previously installed casing of an upper borehole interval. As a consequence of this procedure the casing of the lower interval is of smaller diameter than the casing of the upper interval. Thus, the casings are in a nested arrangement with casing diameters decreasing in downward direction. Cement annuli are provided between the outer surfaces of the casings and the borehole wall to seal the casings from the borehole wall. As a consequence of this nested arrangement a relatively large borehole diameter is required at the upper part of the wellbore. Such a large borehole diameter involves increased costs due to heavy casing handling equipment, large drill bits and increased volumes of drilling fluid and drill cuttings. Moreover, increased drilling rig time is involved due to required cement pumping, cement hardening, required equipment changes due to large variations in hole diameters drilled in the course of the well, and the large volume of cuttings drilled and removed.

The present invention is directed to overcoming one or more of the limitations of the existing procedures for forming and/or repairing wellbore casings.

Summary of the Invention

According to the present invention there is provided a method for forming a mono diameter wellbore casing within a borehole that includes a preexisting wellbore casing, comprising:

supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion device within the borehole;

increasing the size of the adjustable expansion device;

displacing the adjustable expansion device upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member; and

displacing the adjustable expansion device upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member and a portion of the preexisting wellbore casing that overlaps with an end of the remaining portion of the expandable tubular member.

Preferably, the method further comprises reducing the size of the adjustable expansion device after the portion of the expandable tubular member has been radially expanded and plastically deformed.

Preferably, the method further comprises fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member after reducing the size of the adjustable expansion device.

Preferably, the method further comprises injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the borehole.

Preferably, the method further comprises displacing the adjustable expansion cone upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member.

Preferably, the method further comprises displacing the adjustable expansion cone upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform the end of the remaining portion of the expandable tubular member that overlaps with the preexisting wellbore casing.

Brief Description of the Drawings

Fig. 1 is a fragmentary cross-sectional illustration of the placement of an embodiment of an apparatus for radially expanding and plastically deforming a tubular member within a preexisting structure.

Fig. 2 is a fragmentary cross-sectional illustration of apparatus of Fig. 1 after displacing the adjustable expansion mandrel and the float shoe downwardly out of the end of the expandable tubular member.

Fig. 3 is a fragmentary cross-sectional illustration of the apparatus of Fig. 2 after expanding the adjustable expansion mandrel.

Fig. 4 is a fragmentary cross-sectional illustration of the apparatus of Fig. 3 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 5 is a fragmentary cross-sectional illustration of the apparatus of Fig. 4 after displacing the actuator, locking device, and tubular support member upwardly relative to the adjustable expansion mandrel and the expandable tubular member.

Fig. 6 is a fragmentary cross-sectional illustration of the apparatus of Fig. 5 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 6a is a fragmentary cross-sectional illustration of the apparatus of Fig. 6 that include one or more cup seals positioned above the adjustable expansion mandrel for defining an annular pressure chamber above the adjustable expansion mandrel.

Fig. 7 is a fragmentary cross-sectional illustration of the placement of an embodiment of an apparatus for drilling a borehole and radially expanding and plastically deforming a tubular member within the drilled borehole.

Fig. 8 is a fragmentary cross-sectional illustration of the apparatus of Fig. 7 after pivoting the drilling elements of the drilling member radially inwardly.

Fig. 9 is a fragmentary cross-sectional illustration of apparatus of Fig. 8 after displacing the adjustable expansion mandrel and drilling member downwardly out of the end of the expandable tubular member.

Fig. 10 is a fragmentary cross-sectional illustration of the apparatus of Fig. 9 after expanding the adjustable expansion mandrel.

Fig. 11 is a fragmentary cross-sectional illustration of the apparatus of Fig. 10 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 12 is a fragmentary cross-sectional illustration of the apparatus of Fig. 11 after displacing the actuator, locking device, and tubular support member upwardly relative to the adjustable expansion mandrel and the expandable tubular member.

Fig. 13 is a fragmentary cross-sectional illustration of the apparatus of Fig. 12 after displacing the adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 14 is a fragmentary cross-sectional illustration of the placement of an embodiment of an apparatus for radially expanding and plastically deforming a tubular member within a preexisting structure.

Fig. 15 is a fragmentary cross-sectional illustration of the apparatus of Fig. 14 after displacing the lower adjustable expansion mandrel and float shoe downwardly out of the end of the expandable tubular member.

Fig. 16 is a fragmentary cross-sectional illustration of the apparatus of Fig. 15 after expanding the lower adjustable expansion mandrel.

Fig. 17 is a fragmentary cross-sectional illustration of the apparatus of Fig. 16 after displacing the lower adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 18 is a fragmentary cross-sectional illustration of the apparatus of Fig. 17 after displacing the upper and lower adjustable expansion mandrels downwardly relative to the expandable tubular member.

Fig. 19 is a fragmentary cross-sectional illustration of the apparatus of Fig. 18 after collapsing the lower adjustable expansion mandrel and expanding the upper adjustable expansion mandrel.

Fig. 20 is a fragmentary cross-sectional illustration of the apparatus of Fig. 19 after displacing the upper adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 21 is a fragmentary cross-sectional illustration of the apparatus of Fig. 20 after displacing the tubular support member, the locking device, and the actuator upwardly relative to the upper adjustable expansion mandrel and the expandable tubular member.

Fig. 22 is a fragmentary cross-sectional illustration of the apparatus of Fig. 21 after displacing the upper adjustable expansion mandrel upwardly to radially expand and plastically deform the expandable tubular member.

Fig. 23 is a fragmentary cross-sectional illustration of a mono diameter wellbore casing formed using one or more of the apparatus of Figs. 1-22.

Figs. 24a-24k are fragmentary cross sectional illustrations of the placement of an exemplary embodiment of an apparatus for radially expanding and plastically deforming a tubular member within a wellbore that traverses a subterranean formation.

Fig. 25a-25f are fragmentary cross sectional and perspective illustrations of the expansion cone assembly of the apparatus of Figs. 24a-24k.

Fig. 25g is a perspective illustration of a float shoe locking dog.

Fig. 25h is a fragmentary cross sectional illustration of the design and operation of the casing gripper locking dogs.

Figs. 26a-26k are fragmentary cross sectional illustrations of the apparatus of Figs. 24a-24k after expanding the expansion cone assembly.

Figs. 27a-27b are a fragmentary cross sectional and perspective illustrations of the expansion cone assembly of the apparatus of Figs. 26a-26k.

Figs. 28a-28j are fragmentary cross sectional illustrations of the apparatus of Figs. 26a-26k during the upward displacement of the expansion cone assembly by the actuators to radially expand and plastically deform a portion of the casing.

Figs. 29a-29m are fragmentary cross sectional illustrations of the apparatus of Figs. 28a-28j after the collapse of the expansion cone assembly.

Fig. 30a-30c are fragmentary cross sectional illustrations of the process for collapsing the expansion cone assembly of the apparatus of Figs. 29a-29m.

Figs. 31a-31n are fragmentary cross sectional illustrations of the apparatus of Figs. 29a-29m after the plastic deformation and radial expansion of the sealing sleeve and the disengagement of the casing from the locking dogs of the casing lock assembly.

Figs. 32a-32k are fragmentary cross sectional illustrations of the apparatus of Figs. 31a-31n after setting down the apparatus onto the bottom of the wellbore to open the bypass valve in the shoe and expand the expansion cone assembly.

Figs. 33a-33p are fragmentary cross sectional illustrations of the apparatus of Figs. 32a-32k during the radial expansion and plastic deformation of the casing.

Figs. 34a-34l are fragmentary cross sectional illustrations of the apparatus of Figs. 33a-33p during the radial expansion and plastic deformation of a portion of the casing that overlaps within a preexisting wellbore casing within the wellbore.

Figs. 35a-35l are fragmentary cross sectional illustrations of the apparatus of Figs. 28a-28j during the emergency collapse of the expansion cone assembly.

Figs. 36a-36b are fragmentary cross sectional illustrations of several exemplary embodiments of the operation of the pressure balance piston.

Detailed Description of the Illustrative Embodiments

Referring to Fig. 1, an exemplary embodiment of an apparatus 10 for radially expanding and plastically deforming a tubular member 12 includes a tubular support member 14 that extends into the tubular member that is coupled to an end of a locking device 16 for controllably engaging the tubular member. Another end of the locking device 16 is coupled to a tubular support member 18 that is coupled to an end of an actuator 20. Another end of the actuator 20 is coupled to a tubular support member 22 that is coupled to an end of an adjustable expansion mandrel 24 for radially expanding and plastically deforming the tubular member 12. Another end of the adjustable expansion mandrel 24 is coupled to a tubular support member 26 that is coupled to an end of a float shoe 28 that mates with and is at least partially received within a lower

end of the tubular member 12. In an exemplary embodiment, the locking device 16, the tubular support member 18, the actuator 20, the tubular support member 22, the adjustable expansion mandrel 24, and the tubular support member 26 are positioned within the tubular member 12.

In an exemplary embodiment, the tubular member 12 includes one or more solid and/or slotted tubular members, and one or more of the solid and/or slotted tubular members include resilient sealing members coupled to the exterior surfaces of the solid and/or slotted tubular members for engaging the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore. In an exemplary embodiment, the tubular support members, 14, 18, 22, and 26 define corresponding passages, that may or may not be valveable, for conveying fluidic materials into and/or through the apparatus 10.

In an exemplary embodiment, the locking device 16 includes one or more conventional controllable locking devices such as, for example, slips and/or dogs for controllably engaging the tubular member 12. In an exemplary embodiment, the locking device 16 is controlled by injecting fluidic materials into the locking device.

In an exemplary embodiment, the actuator 20 is a conventional actuator that is adapted to displaced the adjustable expansion mandrel 24 and float shoe 28 upwardly or downwardly relative to the actuator.

In an exemplary embodiment, the adjustable expansion mandrel 24 is a conventional adjustable expansion mandrel that may be expanded to a larger outside dimension or collapsed to a smaller outside dimension and includes external surfaces for engaging the tubular member 12 to thereby radially expand and plastically deform the tubular member when the adjustable expansion mandrel is expanded to the larger outside dimension. In an alternative embodiment, the adjustable expansion mandrel 24 may include a rotary adjustable expansion device such as, for example, the commercially available rotary expansion devices of Weatherford International, Inc. In several alternative embodiments, the cross sectional profile of the adjustable expansion mandrel 24 for radial expansion operations may, for example, be an n-sided shape, where n may vary from 2 to infinity, and the side shapes may include straight line segments, arcuate segments, parabolic segments, and/or hyperbolic segments. In

several alternative embodiments, the cross sectional profile of the adjustable expansion mandrel 24 may, for example, be circular, oval, elliptical, and/or multifaceted.

In an exemplary embodiment, the float shoe 28 is a conventional float shoe.

In an exemplary embodiment, the apparatus 10 is positioned within a preexisting structure 30 such as, for example, a wellbore that traverses a subterranean formation 32. The wellbore 30 may have any orientation from vertical to horizontal. In several exemplary embodiments, the wellbore 30 may include one or more preexisting solid and/or slotted and/or perforated wellbore casings that may or may not overlap with one another within the wellbore.

As illustrated in Fig. 2, the adjustable expansion mandrel 24 and the float shoe 28 are then displaced downwardly out of the tubular member 12 by the actuator 20. During the downward displacement of the adjustable expansion mandrel 24 and the float shoe 28 out of the tubular member 12, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 3, the adjustable expansion mandrel 24 is then expanded to the larger dimension. In several alternative embodiments, the adjustable expansion mandrel 24 may be expanded to the larger dimension by, for example, injecting a fluidic material into the adjustable expansion mandrel and/or by impacting the float shoe 28 on the bottom of the wellbore 30. After expanding the adjustable expansion mandrel 24 to the larger dimension, expansion surfaces 24a are defined on the adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12. In an exemplary embodiment, the expansion surfaces 24a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 4, the adjustable expansion mandrel 24 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion of the

tubular member 12. In an exemplary embodiment, during the upward displacement of the adjustable expansion mandrel 24, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore 30. In an exemplary embodiment, the interface between the expansion surfaces 24a of the adjustable expansion mandrel 24 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the adjustable expansion mandrel and the tubular member.

As illustrated in Fig. 5, the locking device 16 is then disengaged from the tubular member 12, and the tubular member 12 is supported by the adjustable expansion mandrel 24. The tubular support member 14, the locking device 16, the tubular support member 18, and the actuator 20 are then displaced upwardly relative to the adjustable expansion mandrel 24.

As illustrated in Fig. 6, the locking device 16 then engages the tubular member 12 to maintain the tubular member in a stationary position relative to the tubular support member 14, and the adjustable expansion mandrel 24 is displaced upwardly relative by the actuator 20 to radially expand and plastically deform another portion of the tubular member.

In an exemplary embodiment, the operations of Figs. 5 and 6 are then repeated until the entire length of the tubular member 12 is radially expanded and plastically deformed by the adjustable expansion mandrel 24. In several alternative embodiments, the adjustable expansion mandrel 24 may be collapsed to the smaller dimension prior to the further, or complete, radial expansion and plastic deformation of the tubular member 12.

In several alternative embodiments, as illustrated in Fig. 6a, the apparatus 10 further includes one or more cup seals 34 that are coupled to the tubular support member 22 and engage the tubular member 12 to define an annular chamber 36 above the adjustable expansion cone 24, and fluidic materials 38 are injected into the tubular

member 12 through passages defined within the tubular support member 14, the locking device 16, the tubular support member 18, the actuator 20, the tubular support member 22, the adjustable expansion mandrel 24, the tubular support member 26, and the float shoe 28 to thereby pressurize the annular chamber 36. In this manner, the resulting pressure differential created across the cup seals 34 causes the cup seals to pull the adjustable expansion mandrel 24 upwardly to radially expand and plastically deform the tubular member 12. In several alternative embodiments, the injection of the fluidic material 38 into the tubular member 12 is provided in combination with, or in the alternative to, the upward displacement of the expansion mandrel 24 by the actuator 20. In several alternative embodiments, during the injection of the fluidic material 38, the locking device 16 is disengaged from the tubular member 12.

Referring to Fig. 7, an alternative embodiment of an apparatus 100 for radially expanding and plastically deforming the tubular member 12 is substantially identical in design and operation to the apparatus 10 with the addition of one or more conventional drilling members 40a-40b that are pivotally coupled to the float shoe 28. During operation of the apparatus 100, the drilling members 40a-40b may be operated to extend the length and/or diameter of the wellbore 30, for example, by rotating the apparatus and/or by injecting fluidic materials into the apparatus to operate the drilling members.

As illustrated in Fig. 7, in an exemplary embodiment, the apparatus 100 is initially positioned within the preexisting structure 30.

As illustrated in Fig. 8, in an exemplary embodiment, the drilling members 40a-40b may then be pivoted inwardly in a conventional manner.

As illustrated in Fig. 9 the adjustable expansion mandrel 24, the float shoe 28, and the drilling members 40a-40b are then displaced downwardly out of the tubular member 12 by the actuator 20. During the downward displacement of the adjustable expansion mandrel 24, the float shoe 28, and the drilling members 40a-40b out of the tubular member 12, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 10, the adjustable expansion mandrel 24 is then expanded to the larger dimension. In several alternative embodiments, the adjustable expansion mandrel 24 may be expanded to the larger dimension by, for example, injecting a fluidic material into the adjustable expansion mandrel and/or by impacting the drilling members 40a-40b on the bottom of the wellbore 30. After expanding the adjustable expansion mandrel 24 to the larger dimension, expansion surfaces 24a are defined on the adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12. In an exemplary embodiment, the expansion surfaces 24a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 11, the adjustable expansion mandrel 24 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion of the tubular member 12. In an exemplary embodiment, during the upward displacement of the adjustable expansion mandrel 24, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore 30. In an exemplary embodiment, the interface between the expansion surfaces 24a of the adjustable expansion mandrel 24 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the adjustable expansion mandrel and the tubular member.

As illustrated in Fig. 12, the locking device 16 is then disengaged from the tubular member 12, and the tubular member 12 is supported by the adjustable expansion mandrel 24. The tubular support member 14, the locking device 16, the tubular support member 18, and the actuator 20 are then displaced upwardly relative to the adjustable expansion mandrel 24.

As illustrated in Fig. 13, the locking device 16 then engages the tubular member 12 to maintain the tubular member in a stationary position relative to the tubular support

member 14, and the adjustable expansion mandrel 24 is displaced upwardly relative by the actuator 20 to radially expand and plastically deform another portion of the tubular member.

In an exemplary embodiment, the operations of Figs. 12 and 13 are then repeated until the entire length of the tubular member 12 is radially expanded and plastically deformed by the adjustable expansion mandrel 24. In several alternative embodiments, the adjustable expansion mandrel 24 may be collapsed to the smaller dimension prior to the further, or complete, radial expansion and plastic deformation of the tubular member 12.

Referring to Fig. 14, an alternative embodiment of an apparatus 200 for radially expanding and plastically deforming the tubular member 12 is substantially identical in design and operation to the apparatus 10 except that the adjustable expansion mandrel 24 has been replaced by an upper adjustable expansion mandrel 202 that is coupled to the tubular support member 22, a tubular support member 204 that is coupled to the upper adjustable expansion mandrel, and a lower adjustable expansion mandrel 206 that is coupled to the tubular support member 204 and the tubular support member 26.

The upper and lower adjustable expansion mandrels, 202 and 206, may be conventional adjustable expansion mandrels that may be expanded to larger outside dimensions or collapsed to smaller outside dimensions and include external surfaces for engaging the tubular member 12 to thereby radially expand and plastically deform the tubular member when the adjustable expansion mandrels are expanded to the larger outside dimensions. In an alternative embodiment, the upper and/or lower adjustable expansion mandrels, 202 and 206, may include rotary adjustable expansion devices such as, for example, the commercially available rotary expansion devices of Weatherford International, Inc. In an exemplary embodiment, the tubular support member 204 defines a passage, that may, or may not, be valveable, for conveying fluidic materials into and/or through the apparatus 200. In several alternative embodiments, the cross sectional profiles of the adjustable expansion mandrels, 202 and 206, for radial expansion operations may, for example, be n-sided shapes, where n may vary from 2 to infinity, and the side shapes may include straight line segments, arcuate segments, parabolic segments, and/or hyperbolic segments. In several

alternative embodiments, the cross sectional profiles of the adjustable expansion mandrels, 202 and 206, may, for example, be circular, oval, elliptical, and/or multifaceted.

As illustrated in Fig. 14, in an exemplary embodiment, the apparatus 200 is initially positioned within the preexisting structure 30.

As illustrated in Fig. 15, the lower adjustable expansion mandrel 206 and the float shoe 28 are then displaced downwardly out of the tubular member 12 by the actuator 20. During the downward displacement of the lower adjustable expansion mandrel 206 and the float shoe 28 out of the tubular member 12, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 16, the lower adjustable expansion mandrel 206 is then expanded to the larger dimension. In several alternative embodiments, the lower adjustable expansion mandrel 206 may be expanded to the larger dimension by, for example, injecting a fluidic material into the lower adjustable expansion mandrel and/or by impacting the float shoe 28 on the bottom of the wellbore 30. After expanding the lower adjustable expansion mandrel 206 to the larger dimension, expansion surfaces 206a are defined on the lower adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12. In an exemplary embodiment, the expansion surfaces 206a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 17, the lower adjustable expansion mandrel 206 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion 12a of the tubular member 12. In an exemplary embodiment, during the upward displacement of the lower adjustable expansion mandrel 206, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore 30. In an exemplary

embodiment, the interface between the expansion surfaces 206a of the lower adjustable expansion mandrel 206 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the lower adjustable expansion mandrel and the tubular member. In an exemplary embodiment, the expansion surfaces 206a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 18, the upper and lower adjustable expansion mandrels, 202 and 206, and the float shoe 28 are then displaced downwardly by the actuator 20. During the downward displacement of the upper and lower adjustable expansion mandrels, 202 and 206, and the float shoe 28, the tubular member is maintained in a stationary position relative to the tubular support member 14 by the locking device 16.

As illustrated in Fig. 19, the upper adjustable expansion mandrel 202 is then expanded to the larger dimension and the lower adjustable expansion mandrel 206 is collapsed to the smaller dimension. In an exemplary embodiment, the larger dimension of the upper adjustable expansion mandrel 202 is less than the larger dimension of the lower adjustable expansion mandrel 206. In several alternative embodiments, the upper adjustable expansion mandrel 202 may be expanded to the larger dimension and the lower adjustable expansion mandrel 206 may be collapsed to the smaller dimension by, for example, injecting fluidic material into the upper and/or adjustable expansion mandrel and/or by impacting the float shoe 28 on the bottom of the wellbore 30. After expanding the upper adjustable expansion mandrel 202 to the larger dimension, expansion surfaces 202a are defined on the upper adjustable expansion mandrel that may include, for example, conical, spherical, elliptical, and/or hyperbolic surfaces for radially expanding and plastically deforming the tubular member 12. In an exemplary embodiment, the expansion surfaces 202a also include means for lubricating the interface between the expansion surfaces and the tubular member 12 during the radial expansion and plastic deformation of the tubular member.

As illustrated in Fig. 20, the upper adjustable expansion mandrel 202 is then displaced upwardly by the actuator 20 to thereby radially expand and plastically deform a portion 12b of the tubular member 12 above the portion 12a of the tubular member. In an

exemplary embodiment, the inside diameter of the radially expanded and plastically deformed portion 12a of the tubular member 12 is greater than the inside diameter of the radially expanded and plastically deformed portion 12b of the tubular member. In an exemplary embodiment, during the upward displacement of the upper adjustable expansion mandrel 202, the tubular member 12 is maintained in a stationary position relative to the tubular support member 14 by the locking device 16. In an exemplary embodiment, the tubular member 12 is radially expanded and plastically deformed into engagement with the wellbore 30 and/or one or more preexisting wellbore casings coupled to the wellbore 30. In an exemplary embodiment, the interface between the expansion surfaces 202a of the upper adjustable expansion mandrel 202 and the tubular member 12 is not fluid tight in order to facilitate the lubrication of the interface between the expansion surface of the upper adjustable expansion mandrel and the tubular member.

As illustrated in Fig. 21, the locking device 16 is then disengaged from the tubular member 12, and the tubular member 12 is supported by the upper adjustable expansion mandrel 202. The tubular support member 14, the locking device 16, the tubular support member 18, and the actuator 20 are then displaced upwardly relative to the upper adjustable expansion mandrel 202 and the tubular member 12.

As illustrated in Fig. 22, the locking device 16 then engages the tubular member 12 to maintain the tubular member in a stationary position relative to the tubular support member 14, and the upper adjustable expansion mandrel 202 is displaced upwardly relative by the actuator 20 to radially expand and plastically deform the portion 12b of the tubular member.

In an exemplary embodiment, the operations of Figs. 21 and 22 are then repeated until the remaining length of the portion 12b of the tubular member 12 is radially expanded and plastically deformed by the upper adjustable expansion mandrel 202. In several alternative embodiments, the upper adjustable expansion mandrel 202 may be collapsed to the smaller dimension prior to the further, or complete, radial expansion and plastic deformation of the tubular member 12.

Referring to Fig. 23, in an exemplary embodiment, the method and apparatus of one or more of Figs. 1-22 are repeated to provide a mono diameter wellbore casing 300 within a borehole 302 that traverses a subterranean formation 304 by successively overlapping and radially expanding and plastically deforming wellbore casing 306a-306d within the wellbore. In this manner, a wellbore casing 300 is provided that defines an interior passage having a substantially constant cross sectional area throughout its length. In several alternative embodiments, the cross section of the wellbore casing 300 may be, for example, square, rectangular, elliptical, oval, circular and/or faceted.

Referring to Figs. 24a-24k, an exemplary embodiment of an apparatus 400 for radially expanding and plastically deforming a tubular member includes a tubular support member 402 that defines a longitudinal passage 402a that is threadably coupled to and received within an end of a tool joint adaptor 404 that defines a longitudinal passage 404a and radial passages 404b and 404c.

The other end of the tool joint adaptor 404 receives and is threadably coupled to an end of a gripper upper mandrel 406 that defines a longitudinal passage 406a, external radial mounting holes, 406b and 406c, an external annular recess 406d, an external annular recess 406e, hydraulic port 406f, an internal annular recess 406g, hydraulic port 406h, external radial mounting holes, 406i and 406j, and includes a flange 406k, and a flange 406l. Torsional locking pins, 408a and 408b, are coupled to the external radial mounting holes, 406b and 406c, respectively, of the gripper upper mandrel 406 and received within the radial passages, 404b and 404c, respectively, of the tool joint adaptor 404.

A spring retainer sleeve 410 that includes a flange 410a receives and is threadably coupled to the gripper upper mandrel 406 between an end face of the tool joint adaptor 404 and the flange 406k of the gripper upper mandrel. A bypass valve body 412 receives and is movably coupled to the gripper upper mandrel 406 that defines radial passages, 412a and 412b, and an internal annular recess 412c includes a flange 412d.

An end of a spring cover 414 receives and is movably coupled to the spring retainer sleeve 410 that defines an internal annular recess 414a. The other end of the spring

cover 414 receives and is threadably coupled to an end of the bypass valve body 412. A spring guide 416, a spring 418, and a spring guide 420 are positioned within an annular chamber 422 defined between the spring cover 414 and the flange 406k of the gripper upper mandrel 406. Furthermore, an end of the spring guide 416 abuts an end face of the spring retainer sleeve 410.

Casing gripper locking dogs, 424a and 424b, are received and pivotally mounted within the radial passages, 412a and 412b, respectively, of the bypass valve body 412. An end of each of the casing gripper locking dogs, 424a and 424b, engage and are received within the outer annular recess 406d of the gripper upper mandrel 406. An end of a debris trap 426 receives and is threadably coupled to an end of the bypass valve body 412, and the other end of the debris trap receives and is movably coupled to the flange 406l of the gripper upper mandrel 406.

An end of a gripper body 428 receives and is threadably coupled to an end of the gripper upper mandrel 406 that defines a longitudinal passage 428a, radial passages, 428b and 428c, radial slip mounting passages, 428d-428m, and radial passages, 428n and 428o, includes a flange 428p.

Hydraulic slip pistons 432a-432j are movably mounted with the radial slip mounting passages 428d-428m, respectively, for movement in the radial direction. Retainers 434a-434j are coupled to the exterior of the flange 428p of the gripper body 428 for limiting the outward radial movement of the hydraulic slip pistons 432a-432j, respectively, and springs 436a-436j are positioned within the radial slip mounting passages, 428d-428m, respectively, of the gripper body between the hydraulic slip pistons, 432a-432j, and the retainers, 434a-434j, respectively. During operation of the apparatus 400, pressurization of the radial slip mounting passages, 428d-428m, displaces the hydraulic slip pistons, 432a-432j, respectively, radially outwardly and compresses the springs, 436a-436j, respectively, and during depressurization of the radial slip mounting passages, 428d-428m, springs, 436a-436j, respectively, displace the hydraulic slip pistons, 432a-432j, inwardly. In an exemplary embodiment, displacement of the hydraulic slip pistons 432a-432j radially outwardly permits at least portions of the hydraulic slip pistons to engage and grip an outer tubular member.

Torsional locking pins, 438a and 438b, are coupled to the external radial mounting holes, 406i and 406j, respectively, of the gripper upper mandrel 406 and received within the radial passages, 428b and 428c, respectively, of the gripper body 428.

An end of a gripper body 440 receives and is threadably coupled to an end of the gripper body 428 that defines a longitudinal passage 440a, radial passages, 440b and 440c, radial slip mounting passages, 440d-440m, and radial passages, 440n and 440o, includes a flange 440p.

Hydraulic slip pistons 442a-442j are movably mounted with the radial slip mounting passages 440d-440m, respectively, for movement in the radial direction. Retainers 444a-444j are coupled to the exterior of the flange 440p of the gripper body 440 for limiting the outward radial movement of the hydraulic slip pistons 442a-442j, respectively, and springs 446a-446j are positioned within the radial slip mounting passages, 440d-440m, respectively, of the gripper body between the hydraulic slip pistons, 442a-442j, and the retainers, 444a-444j, respectively. During operation of the apparatus 400, pressurization of the radial slip mounting passages, 440d-440m, displaces the hydraulic slip pistons, 442a-442j, respectively, radially outwardly and compresses the springs, 446a-446j, respectively, and during depressurization of the radial slip mounting passages, 440d-440m, the springs, 446a-446j, respectively, displace the hydraulic slip pistons, 442a-442j, radially inward. In an exemplary embodiment, displacement of the hydraulic slip pistons 442a-442j radially outwardly permits at least portions of the hydraulic slip pistons to engage and grip an outer tubular member.

Torsional locking pins, 448a and 448b, are coupled to the external radial mounting holes, 428n and 428o, respectively, of the gripper body 428 and received within the radial passages, 440b and 440c, respectively, of the gripper body 440.

An end of a tool joint adaptor 450 that defines a longitudinal passage 450a, radial passages, 450b and 450c, and an inner annular recess 450d, receives and is threadably coupled to an end of the gripper body 440. Torsional locking pins, 452a and 452b, are coupled to the external radial mounting holes, 440n and 440o, respectively,

of the gripper body 428 and received within the radial passages, 450b and 450c, respectively, of the tool joint adaptor 450.

A bypass tube 454 that defines a longitudinal passage 454a is received within the longitudinal passages, 406a, 428a, 440a, and 450a, of the gripper upper mandrel 406, the gripper body 428, the gripper body 440, and the tool joint adaptor 450, respectively, is coupled to the recess 406g of the gripper upper mandrel at one end and is coupled to the recess 450d of the tool joint adaptor at the other end.

An end of a cross over adaptor 456 that defines a longitudinal passage 456a receives and is threadably coupled to an end of the tool joint adaptor 450. The other end of the cross over adaptor 456 is received within and is coupled to an end of a tool joint adaptor 458 that defines a longitudinal passage 458a and external radial mounting holes, 458b and 458c.

An end of a positive casing locking body 460 that defines a tapered longitudinal passage 460a and radial passages, 460b and 460c, receives and is threadably coupled to the other end of the tool joint adaptor 458. Torsional locking pins, 462a and 462b, are coupled to the external radial mounting holes, 458b and 458c, respectively, of the tool joint adaptor 458 and received within the radial passages, 460b and 460c, respectively, of the positive casing locking body 460.

An end of a positive casing locking dog 464 mates with, is received within, and is coupled to the other end of the positive casing locking body 460 that includes internal flanges, 464a and 464b, and an external flange 464c. In an exemplary embodiment, the external flange 464c of the positive casing locking dog 464 includes an ribbed external surface 464d that engages and locks onto a ribbed internal surface 466a of a positive casing locking collar 466.

One end of the positive casing locking collar 466 is threadably coupled to a casing 468 and the other end of the positive casing locking collar is threadably coupled to a casing 470 that defines radial mounting holes, 470a and 470b, at a lower end thereof. In this manner, the casings, 468 and 470, are also engaged by and locked onto the positive casing locking dog 464.

The other end of the positive casing locking dog 464 mates with, is received within, and is coupled to an end of a positive casing locking body 472 that defines a tapered longitudinal passage 472a and radial passages, 472b and 472c. The other end of the positive casing locking body 472 receives, mates with, and is coupled to an end of a casing lock barrel adaptor 474 that defines external radial mounting holes, 474a and 474b, and external radial mounting holes, 474c and 474d. Torsional locking pins, 475a and 475b, are coupled to the external radial mounting holes, 474a and 474b, respectively, of the casing lock barrel adaptor 474 and received within the radial passages, 472b and 472c, respectively, of the positive casing locking body 472.

An end of a positive casing lock releasing mandrel 476 that defines a longitudinal passage 476a, an external annular recess 476b, an external annular recess 476c, an external annular recess 476d, and an external annular recessed end portion 476e, is received within and movably coupled to an end of the tool joint adaptor 458. The middle portion of the positive casing lock releasing mandrel 476 is received within and mates with the internal flanges, 464a and 464b, of the positive casing locking dogs 464. The other end of the positive casing lock releasing mandrel 476 is received within and is movably coupled to the end of the casing lock barrel adaptor 474, and the external annular recessed portion 476e of the positive casing lock releasing mandrel is threadably coupled to and received within an end of a positive casing lock lower mandrel 478 that defines a longitudinal passage 478a, external radial mounting holes, 478b and 478c, and an external annular recessed end portion 478d.

A shear pin ring 480 that defines radial passages, 480a and 480b, receives and mates with the positive casing lock lower mandrel 478. Shear pins, 482a and 482b, are coupled to the external radial mounting holes, 478b and 478c, respectively, of the positive casing lock lower mandrel 478 and are received within the radial passages, 480a and 480b, respectively, of the shear pin ring 480.

An end of an actuator barrel 484 that defines a longitudinal passage 484a, radial passages, 484b and 484c, and radial passages, 484d and 484e, is threadably coupled to an end of the casing lock barrel adaptor 474. Torsional locking pins, 486a and 486b, are coupled to the external radial mounting holes, 474c and 474d, respectively, of the

casing lock barrel adaptor and are received within the radial passages, 484b and 484c, respectively, of the actuator barrel.

The other end of the actuator barrel 484 is threadably coupled to an end of a barrel connector 486 that defines an internal annular recess 486a, external radial mounting holes, 486b and 486c, radial passages, 486d and 486e, and external radial mounting holes, 486f and 486g. A sealing cartridge 488 is received within and coupled to the internal annular recess 486a of the barrel connector 486 for fluidicly sealing the interface between the barrel connector and the sealing cartridge. Torsional locking pins, 490a and 490b, are coupled to and mounted within the external radial mounting holes, 486b and 486c, respectively, of the barrel connector 486 and received within the radial passages, 484d and 484e, of the actuator barrel 484.

The other end of the barrel connector 486 is threadably coupled to an end of an actuator barrel 492 that defines a longitudinal passage 492a, radial passages, 492b and 492c, and radial passages, 492d and 492e. Torsional locking pins, 494a and 494b, are coupled to and mounted within the external radial mounting holes, 486f and 486g, respectively, of the barrel connector 486 and received within the radial passages, 492b and 492c, of the actuator barrel 492. The other end of the actuator barrel 492 is threadably coupled to an end of a barrel connector 496 that defines an internal annular recess 496a, external radial mounting holes, 496b and 496c, radial passages, 496d and 496e, and external radial mounting holes, 496f and 496g. A sealing cartridge 498 is received within and coupled to the internal annular recess 496a of the barrel connector 496 for fluidicly sealing the interface between the barrel connector and the sealing cartridge. Torsional locking pins, 500a and 500b, are coupled to and mounted within the external radial mounting holes, 496b and 496c, respectively, of the barrel connector 496 and received within the radial passages, 492d and 492e, of the actuator barrel 492.

The end of the barrel connector 496 is threadably coupled to an end of an actuator barrel 502 that defines a longitudinal passage 502a, radial passages, 502b and 502c, and radial passages, 502d and 502e. Torsional locking pins, 504a and 504b, are coupled to and mounted within the external radial mounting holes, 496f and 496g, respectively, of the barrel connector 496 and received within the radial passages, 502b

and 502c, of the actuator barrel 502. The other end of the actuator barrel 502 is threadably coupled to an end of a barrel connector 506 that defines an internal annular recess 506a, external radial mounting holes, 506b and 506c, radial passages, 506d and 506e, and external radial mounting holes, 506f and 506g. Torsional locking pins, 508a and 508b, are coupled to and mounted within the external radial mounting holes, 506b and 506c, respectively, of the barrel connector 506 and received within the radial passages, 502d and 502e, of the actuator barrel 502. A sealing cartridge 510 is received within and coupled to the internal annular recess 506a of the barrel connector 506 for fluidicly sealing the interface between the barrel connector and the sealing cartridge.

The other end of the barrel connector 506 is threadably coupled to an end of an actuator barrel 512 that defines a longitudinal passage 512a, radial passages, 512b and 512c, and radial passages, 512d and 512e. Torsional locking pins, 514a and 514b, are coupled to and mounted within the external radial mounting holes, 506f and 506g, respectively, of the barrel connector 506 and received within the radial passages, 512b and 512c, of the actuator barrel 512. The other end of the actuator barrel 512 is threadably coupled to an end of a lower stop 516 that defines an internal annular recess 516a, external radial mounting holes, 516b and 516c, and an internal annular recess 516d that includes one or more circumferentially spaced apart locking teeth 516e at one end and one or more circumferentially spaced apart locking teeth 516f at the other end. A sealing cartridge 518 is received within and coupled to the internal annular recess 516a of the barrel connector 516 for fluidicly sealing the interface between the barrel connector and the sealing cartridge. Torsional locking pins, 520a and 520b, are coupled to and mounted within the external radial mounting holes, 516b and 516c, respectively, of the barrel connector 516 and received within the radial passages, 512d and 512e, of the actuator barrel 512.

A connector tube 522 that defines a longitudinal passage 522a is received within and sealingly and movably engages the interior surface of the sealing cartridge 488 mounted within the annular recess 486a of the barrel connector 486. In this manner, during longitudinal displacement of the connector tube 522 relative to the barrel connector 486, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector. An end of the

connector tube 522 is received within and is threadably coupled to an end of dart/ball guide 524 that defines a tapered passage 524a at the other end.

The other end of the connector tube 522 is received within and threadably coupled to an end of a piston 526 that defines a longitudinal passage 526a and radial passages, 526b and 526c, that includes a flange 526d at one end. A sealing cartridge 528 is mounted onto and sealingly coupled to the exterior of the piston 526 proximate the flange 526d. The sealing cartridge 528 also mates with and sealingly engages the interior surface of the actuator barrel 492. In this manner, during longitudinal displacement of the piston 526 relative to the actuator barrel 492, a fluidic seal is maintained between the exterior surface of the piston and the interior surface of the actuator barrel.

The other end of the piston 526 receives and is threadably coupled to an end of a connector tube 529 that defines a longitudinal passage 528a. The connector tube 529 is received within and sealingly and movably engages the interior surface of the sealing cartridge 498 mounted within the annular recess 496a of the barrel connector 496. In this manner, during longitudinal displacement of the connector tube 529 relative to the barrel connector 496, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector.

The other end of the connector tube 529 is received within and threadably coupled to an end of a piston 530 that defines a longitudinal passage 530a and radial passages, 530b and 530c, that includes a flange 530d at one end. A sealing cartridge 532 is mounted onto and sealingly coupled to the exterior of the piston 530 proximate the flange 530d. The sealing cartridge 532 also mates with and sealingly engages the interior surface of the actuator barrel 502. In this manner, during longitudinal displacement of the piston 530 relative to the actuator barrel 502, a fluidic seal is maintained between the exterior surface of the piston and the interior surface of the actuator barrel.

The other end of the piston 530 receives and is threadably coupled to an end of a connector tube 534 that defines a longitudinal passage 534a. The connector tube 534 is received within and sealingly and movably engages the interior surface of the sealing

cartridge 510 mounted within the annular recess 506a of the barrel connector 506. In this manner, during longitudinal displacement of the connector tube 534 relative to the barrel connector 506, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector.

The other end of the connector tube 534 is received within and threadably coupled to an end of a piston 536 that defines a longitudinal passage 536a, radial passages, 536b and 536c, and external radial mounting holes, 536d and 536e, that includes a flange 536f at one end. A sealing cartridge 538 is mounted onto and sealingly coupled to the exterior of the piston 536 proximate the flange 536d. The sealing cartridge 538 also mates with and sealingly engages the interior surface of the actuator barrel 512. In this manner, during longitudinal displacement of the piston 536 relative to the actuator barrel 512, a fluidic seal is maintained between the exterior surface of the piston and the interior surface of the actuator barrel.

The other end of the piston 536 is received within and threadably coupled to an end of a lock nut 540 that defines radial passages, 540a and 540b, and includes one or more circumferentially spaced apart locking teeth 540c at the other end for engaging the circumferentially spaced apart locking teeth 516e of the lower stop 516.

A threaded bushing 542 is received within and threadably coupled to the circumferentially spaced apart locking teeth 540c of the lock nut 540. An end of a connector tube 544 that defines a longitudinal passage 544a is received within and is threadably coupled to the threaded bushing 542. A sealing sleeve 546 is received within and is threadably coupled to adjacent ends of the piston 536 and the connector tube 544 for fluidicly sealing the interface between the end of the piston and the end of the connector tube. Torsional locking pins, 548a and 548b, are mounted within and coupled to the external radial mounting holes, 536d and 536e, respectively, of the piston 536 that are received within the radial passages, 540a and 540b, of the stop nut 540.

The connector tube 544 is received within and sealingly and movably engages the interior surface of the sealing cartridge 518 mounted within the annular recess 516a of the barrel connector 516. In this manner, during longitudinal displacement of the

connector tube 544 relative to the barrel connector 516, a fluidic seal is maintained between the exterior surface of the connector tube and the interior surface of the barrel connector.

The other end of the connector tube 544 is received within and is threadably coupled to a threaded bushing 550. The threaded bushing 550 is received within and threadably coupled to a lock nut 552 that defines radial passages, 552a and 552b, and includes one or more circumferentially spaced apart locking teeth 552c at one end for engaging the circumferentially spaced apart locking teeth 516f of the lower stop 516. The other end of the lock nut 552 receives and is threadably coupled to an end of tool joint adaptor 554 that defines a longitudinal passage 554a, external radial mounting holes, 554b and 554c. Torsional locking pins, 556a and 556b, are mounted within and coupled to the external radial mounting holes, 554b and 554c, respectively, of the tool joint adaptor 554 that are received within the radial passages, 552a and 552b, of the stop nut 552. A sealing sleeve 558 is received within and is threadably coupled to adjacent ends of the connector tube 544 and the tool joint adaptor 554 for fluidicly sealing the interface between the end of the connector tube and the end of the tool joint adaptor.

The other end of the tool joint adaptor 554 is received within and threadably coupled to an end of a tool joint adaptor 560 that defines a longitudinal passage 560a. A torsion plate 562 is received within and threadably coupled to the other end of the tool joint adaptor 560 that defines a longitudinal passage 562a and includes one or more circumferentially spaced apart locking teeth 562b at one end. An end of an upper bushing 564 is also received within and threadably coupled to the other end of the tool joint adaptor 560 proximate the torsion plate 562 that receives and is threadably coupled to an end of a cup mandrel 566 that defines a longitudinal passage 566a and includes a plurality of circumferentially spaced apart locking teeth 566b at one end for engaging the circumferentially spaced apart locking teeth 562b of the torsion plate 562. The end of the cup mandrel 566 is further positioned proximate an end face of the torsion plate 562.

A thimble 568 is mounted on and is threadably coupled to the cup mandrel 566 proximate an end face of the upper bushing 564. An inner thimble 570 is mounted on

and is threadably coupled to the cup mandrel 566 proximate an end of the thimble 568, and one end of the inner thimble is received within and mates with the end of the thimble. A resilient packer cup 572 is mounted on and sealingly engages the cup mandrel 566 proximate an end of the inner thimble 570, and one end of the packer cup is received within and mates with the end of the inner thimble. A packer cup backup ring 574 is mounted on the inner thimble 570 proximate an end face of the thimble 568, and an end of the packer cup backup ring 574 receives and mates with the packer cup 572. A spacer 576 is mounted on and threadably engages the cup mandrel 566 proximate an end face of the packer cup 572.

A thimble 578 is mounted on and is threadably coupled to the cup mandrel 566 proximate an end of the spacer 576. An inner thimble 580 is mounted on and is threadably coupled to the cup mandrel 566 proximate an end of the thimble 578, and one end of the inner thimble is received within and mates with the end of the thimble. A resilient packer cup 582 is mounted on and sealingly engages the cup mandrel 566 proximate an end of the inner thimble 580, and one end of the packer cup is received within and mates with the end of the inner thimble. A packer cup backup ring 584 is mounted on the inner thimble 580 proximate an end face of the thimble 578, and an end of the packer cup backup ring 584 receives and mates with the packer cup 582. An adjustable spacer 586 is mounted on and threadably engages the cup mandrel 566 proximate an end face of the packer cup 582.

An end of a cone mandrel 588 that defines a longitudinal passage 588a, an external lock ring groove 588b, an external lock ring groove 588c, an external lock ring groove 588d, an external lock ring groove 588e, radial passages, 588f and 588g, and locking dog grooves 588h receives and is threadably coupled to an end of the cup mandrel 566. A shear pin bushing 590 that defines external radial mounting holes, 590a and 590b, at one end and an annular recess 590c at another end and includes circumferentially spaced apart locking teeth 590d at the other end is mounted on and is movably coupled to the cone mandrel 588. Torsional shear pins, 592a and 592b, are mounted within and coupled to the external radial mounting holes, 590a and 590b, respectively, of the shear pin bushing 590 and received within the radial passages, 470a and 470b, respectively, of the end of the casing 470. In this manner, torque loads may be transmitted between the casing 470 and the shear pin bushing 590. A resilient

lock ring 594 is retained in the external lock ring groove 588b of the cone mandrel and received within the internal annular recess 590c at the end of the shear pin bushing 590.

Referring to Figs. 24j, 25a, and 25b, an upper cone retainer 596 receives, mates with, and is coupled to the end of the shear pin bushing 590 that includes an internal flange 596a and an internal upper pivot point flange 596b. An end of an upper cam 598 includes a tubular base 598a that mates with, receives, and is movably coupled to the cone mandrel 588. The tubular base 598a of the upper cam 598 further includes an external flange 598b that is received within and mates with the upper cone retainer 596 proximate the internal flange 596a of the upper cone retainer and a plurality of circumferentially spaced apart locking teeth 598c that engage the circumferentially spaced apart locking teeth 590d of the end of the shear pin bushing 590. In this manner, the upper cam 598 is retained within the upper cone retainer 596 and torque loads may be transmitted between the upper cam and the shear pin bushing 590.

Referring to Figs. 25b and 25c, the upper cam 598 further includes a plurality of circumferentially spaced apart cam arms 598d that extend from the tubular base 598a in the longitudinal direction that mate with, receive, and are movably coupled to the cone mandrel 588. Each cam arm 598d includes an inner surface 598da that is an arcuate cylindrical segment, a first outer surface 598db that is an arcuate cylindrical segment, a second outer surface 598dc that is an arcuate conical segment, and a third outer surface 598dd that is an arcuate cylindrical segment. In an exemplary embodiment, each of the cam arms 598d are identical.

Referring to Figs. 24j, 25a, and 25d, a plurality of circumferentialy spaced apart upper cone segments 600 are interleaved among the cam arms 598d of the upper cam 598. In an exemplary embodiment, each upper cone segment 600 includes a first outer surface 600a that defines a hinge groove 600b, a second outer surface 600c, a third outer surface 600d, a fourth outer surface 600e, a first inner surface 600f, a second inner surface 600g, a third inner surface 600h, and a fourth inner surface 600i. In an exemplary embodiment, the first outer surface 600a, the second outer surface 600c, the fourth outer surface 600e, the first inner surface 600f, the second inner surface 600g, and the fourth inner surface 600i are arcuate cylindrical segments. In an

exemplary embodiment, the third outer surface 600d is an arcuate spherical segment. In an exemplary embodiment, the third inner surface 600h is an arcuate conical segment. In an exemplary embodiment, each of the upper cone segments 600 are identical. In an exemplary embodiment, the hinge grooves 600b of the upper cone segments 600 receive and mate with the pivot point 596b of the upper cone retainer 596. In this manner, the upper cone segments 600 are pivotally coupled to the upper cone retainer 596.

Referring to Figs. 24j, 25a, and 25e, a plurality of circumferentially spaced apart lower cone segments 602 overlap with and are interleaved among the upper cone segments 600. In an exemplary embodiment, each lower cone segment 602 includes a first outer surface 602a that defines a hinge groove 602b, a second outer surface 602c, a third outer surface 602d, a fourth outer surface 602e, a first inner surface 602f, a second inner surface 602g, a third inner surface 602h, and a fourth inner surface 602i. In an exemplary embodiment, the first outer surface 602a, the second outer surface 602c, the fourth outer surface 602e, the first inner surface 602f, the second inner surface 602g, and the fourth inner surface 602*i* are arcuate cylindrical segments. In an exemplary embodiment, the third outer surface 602d is an arcuate spherical segment. In an exemplary embodiment, the third inner surface 602h is an arcuate conical segment. In an exemplary embodiment, each of the lower cone segments 602 are identical.

Referring to Figs. 24j, 25a, 25b, and 25f, a plurality of circumferentially spaced apart cam arms 604a that extend in the longitudinal direction from a tubular base 604b of a lower cam 604 overlap and are interleaved among the circumferentially spaced apart cam arms 598d of the upper cam 598 and mate with, receive, and are movably coupled to the cone mandrel 588. The tubular base 604b of the lower cam 604 mates with, receives, and is movably coupled to the cone mandrel 588 and includes an external flange 604c and a plurality of circumferentially spaced apart locking teeth 604d. Each cam arm 604a includes an inner surface 604aa that is an arcuate cylindrical segment, a first outer surface 604ab that is an arcuate cylindrical segment, a second outer surface 604ac that is an arcuate conical segment, and a third outer surface 604ad that is an arcuate cylindrical segment. In an exemplary embodiment, each of the cam arms 604a are identical.

An end of a lower cone retainer 606 includes an inner pivot point flange 606a that mates with and is received within the hinge grooves 602b of the lower cone segments 602. In this manner, the lower cone segments 602 are pivotally coupled to the lower cone retainer 606. The lower cone retainer 606 further includes an inner flange 606b that mates with and retains the external flange 604c of the lower cam 604. In this manner, the lower cam 604 is retained within the lower cone retainer 606.

The other end of the lower cone retainer 606 receives and is threadably coupled to an end of a release housing 608 that defines a radial passage 608a at another end and includes a plurality of circumferentially spaced apart locking teeth 608b at the end of the release housing for engaging the circumferentially spaced apart locking teeth 604d of the lower cam 604. In this manner, torque loads may be transmitted between the release housing 608 and the lower cam 604. An end of a lower mandrel 610 that defines a longitudinal passage 610a, an external radial mounting hole 610b, and radial passages 610c is received within, mates with, and is movably coupled to the other end of the release housing 608. A torsion locking pin 612 is mounted within and coupled to the external radial mounting hole 610b of the lower mandrel 610 and received within the radial passage 608a of the release housing 608. In this manner, longitudinal and torque loads may be transmitted between the release housing 608 and the lower mandrel 610.

An end of a locking dog retainer sleeve 614 that defines an inner annular recess 614a at one end and includes a plurality of circumferentially spaced apart locking teeth 614b at one end for engaging the locking teeth 604d of the lower cam 604 is received within and threadably coupled to an end of the lower mandrel 610. The locking dog retainer sleeve 614 is also positioned between and movably coupled to the release housing 608 and the cone mandrel 588. Locking dogs 616 are received within the inner annular recess 614a of the locking dog retainer sleeve 614 that releasably engage the locking dog grooves 588h provided in the exterior surface of the cone mandrel 588. In this manner, the locking dogs 616 releasably limit the longitudinal displacement of the lower cone segments 602, lower cam 604, and the lower cone retainer 606 relative to the cone mandrel 588.

A locking ring retainer 618 is received within and is threadably coupled to an end of the lower mandrel 610 that defines an inner annular recess 618a for retaining a resilient locking ring 620 within the lock ring groove 588d of the cone mandrel 588. The locking ring retainer 618 further mates with and is movably coupled to the cone mandrel 588. An end of an emergency release sleeve 622 that defines radial passages 622a, an outer annular recess 622b, and a longitudinal passage 622c is received within and is threadably coupled to an end of the lower mandrel 610. The emergency release sleeve 622 is also received within, mates with, and slidably and sealingly engages an end of the cone mandrel 588.

An end of a pressure balance piston 624 is received within, mates with, and slidably and sealingly engages the end of the lower mandrel 610 and receives, mates with, and is threadably coupled to an end of the cone mandrel 588. The other end of the pressure balance piston 624 receives, mates with, and slidably and sealingly engages the emergency release sleeve 622.

An end of a bypass valve operating probe 626 that defines a longitudinal passage 626a is received within and is threadably coupled to another end of the lower mandrel 610. An end of an expansion cone mandrel 628 that defines radial passages 628a receives and is threadably coupled to the other end of the lower mandrel 610. A sealing sleeve expansion cone 630 is slidably coupled to the other end of the expansion cone mandrel 628 that includes an outer tapered expansion surface 630a. A guide 632 is releasably coupled to another end of the expansion cone mandrel 628 by a retaining collet 634.

An end of an expandable sealing sleeve 636 receives and is mounted on the sealing sleeve expansion cone 630 and the guide 632. The other end of the expandable sealing sleeve 636 receives and is threadably coupled to an end of a bypass valve body 638 that defines radial passages, 638a and 638b. An elastomeric coating 640 is coupled to the exterior of at least a portion of the expandable sealing sleeve 636. An end of a probe guide 642 that defines an inner annular recess 642a is received within and is threadably coupled to an end of the bypass valve body 638 and receives and mates with an end of the bypass valve operating probe 626.

A bypass valve 644 that defines a longitudinal passage 644a and radial passages, 644b and 644c, and includes a collet locking member 644d at one end for releasably engaging an end of the bypass valve operating probe 626 is received within, mates with, and slidably and sealingly engages the bypass valve body 638. An end of a lower mandrel 646 that defines a longitudinal passage 646a receives and is threadably coupled to an end of the bypass valve body 638.

An end of a dart guide sleeve 648 that defines a longitudinal passage 648a is received within and is coupled to an end of the bypass valve body 638 and the other end of the dart guide sleeve 648 is received within and is coupled with the lower mandrel 646. An end of a differential piston 650 that includes an inner flange 650a at another end receives and is coupled to an end of the lower mandrel 646 by one or more shear pins 652. An end of a float valve assembly 654 including a float valve 654a, a valve guard 654b, and a guide nose 654c receives and is threadably coupled to an end of the lower mandrel 646. A plurality of circumferentially spaced apart locking dogs 656 are pivotally coupled to the inner flange 650a of the differential piston 650 and are further supported by an end of the float valve assembly 654.

As illustrated in Figs. 24a-24k, in an exemplary embodiment, during operation of the apparatus 400, the apparatus is initially positioned within a preexisting structure 700 such as, for example, a wellbore that traverses a subterranean formation. In several alternative embodiments, the wellbore 700 may have any inclination from vertical to horizontal. Furthermore, in several alternative embodiments, the wellbore 700 may also include one or more preexisting wellbore casings, or other well construction elements, coupled to the wellbore. During the positioning of the apparatus 400 within the wellbore 700, the casings, 468 and 470, are supported by the positive casing locking dog 464 and the torsional shear pins, 592a and 592b. In this manner, axial and torque loads may be transmitted between the casings, 468 and 470, and the tubular support member 402.

In an exemplary embodiment, as illustrated in Fig. 25h, prior to the assembly of the apparatus 400, the force of the spring 418 applies a sufficient downward longitudinal force to position the ends of the casing gripper locking dogs, 424a and 424b, between the outer annular recesses, 406d and 406e, of the gripper upper mandrel 406 thereby

placing the bypass valve body 412 in a neutral position. In an exemplary embodiment, when the apparatus 400 is assembled by inserting the apparatus into the casing 468, the ends of the casing gripper locking dogs, 424a and 424b, impact the upper end of the casing 468 and are thereby displaced, along with the bypass valve body 412, upwardly relative to the gripper upper mandrel 406 until the ends of the casing gripper locking dogs pivot radially inwardly into engagement with the outer annular recess 406d of the gripper upper mandrel. In this manner, the bypass valve body 412 is positioned in an inactive position, as illustrated in Fig. 24a, that fluidicly decouples the casing gripper hydraulic ports, 406f and 406h. The upward displacement of the bypass valve body 412 relative to the gripper upper mandrel 406 further compresses the spring 418. The bypass valve body 412 is then maintained in the inactive position due to the placement of the casing gripper locking dogs, 424a and 424b, within the casing 468 thereby preventing the ends of the casing gripper locking dogs from pivoting radially outward out of engagement with the outer annular recess 406d.

Referring to Figs. 26a-26k, when the apparatus 400 is positioned at a desired predetermined position within the wellbore 700, a fluidic material 702 is injected into the apparatus through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, 644a, and 646a and out of the apparatus through the float valve 654a. In this manner the proper operation of the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, 644a, and 646a and the float valve 654a may be tested. A dart 704 is then injected into the apparatus with the fluidic material 702 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, and 644a until the dart is positioned and seated in the passage 646a of the lower mandrel 646. As a result of the positioning of the dart 704 in the passage 646a of the lower mandrel 646, the passage of the lower mandrel is thereby closed.

The fluidic material 702 is then injected into the apparatus thereby increasing the operating pressure within the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, 588a, 622c, 610a, 626a, and 644a. Furthermore, the continued injection of the fluidic material 702 into the apparatus 400 also causes the fluidic material 702 to pass through the radial passages,

526b and 526c, 530b and 530c, and 536b and 536c, of the piston 526, 530, and 536, respectively, into an annular pressure chamber 706 defined between the actuator barrel 492 and the connector tube 529, an annular pressure chamber 708 defined between the actuator barrel 502 and the connector tube 534, and an annular pressure chamber 710 defined between the actuator barrel 512 and the connector tube 544.

The pressurization of the annular pressure chambers, 706, 708, and 710 then cause the pistons 526, 530, and 536 to be displaced upwardly relative to the casing 470. As a result, the connector tube 529, the connector tube 534, the connector tube 544, the threaded bushing 550, the lock nut 552, the tool joint adaptor 554, the sealing sleeve 558, the tool joint adaptor 560, the torsion plate 562, the upper bushing 564, the cup mandrel 566, the thimble 568, the inner thimble 570, the packer cup 572, the backup ring 574, the spacer 576, the thimble 578, the inner thimble 580, the packer cup 582, the backup ring 584, the spacer 586, and the cone mandrel 588 are displaced upwardly relative to the casing 470, the shear pin bushing 590, the locking ring 594, the upper cone retainer 596, the upper cam 598, and the upper cone segments 600.

As a result, as illustrated in Figs. 26j, 27a, and 27b, the shear pin bushing 590, the locking ring 594, the upper cone retainer 596, the upper cam 598, and the upper cone segments 600 are displaced downwardly relative to the cone mandrel 588, the lower cone segments 602, and the lower cam 604 thereby driving the upper cone segments 600 onto and up the cam arms 604a of the lower cam 604, and driving the lower cone segments 602 onto and up the cam arms 598d of the upper cam 598. During the outward radial displacement of the upper and lower cone segments, 600 and 602, the upper and cone segments translate towards one another in the longitudinal direction and also pivot about the pivot points, 596b and 606a, of the upper and lower cone retainers, 596 and 606, respectively.

As a result, a segmented expansion cone is formed that includes a substantially continuous outer arcuate spherical surface provided by the axially aligned and interleaved upper and lower expansion cone segments, 600 and 602. Furthermore, the resilient locking ring 594 is relocated from the lock ring groove 588b to the lock ring groove 588c thereby releasably locking the positions of the shear pin bushing 590, the

locking ring 594, the upper cone retainer 596, the upper cam 598, and the upper cone segments 600 relative to the cone mandrel 588.

Referring to Figs. 28a to 28j, the continued injection of the fluidic material 702 into the apparatus 400 continues to pressurize annular pressure chambers, 706, 708, and 710. As a result, an upward axial force is applied to the shear pin bushing 590 that causes the torsional shear pins, 592a and 592b, to be sheared thereby decoupling the wellbore casing 470 from the shear pin bushing 590 and permitting the pistons 526, 530, and 536 to be further displaced upwardly relative to the casing 470. The further upward displacement of the pistons 526, 530, and 536 in turn displaces the cone mandrel 588, the upper cam 598, the upper cone segments 600, the lower cone segments 602, and the lower cam 604 upwardly relative to the casing 470. As a result, the segmented expansion cone provided by the interleaved and axially aligned upper and lower cone segments, 600 and 602, radially expands and plastically deforms a portion of the casing 470.

Referring to Figs. 29a-29m, during the continued injection of the fluidic material 702, the segmented expansion cone provided by the interleaved and axially aligned upper and lower cone segments, 600 and 602, will continue to be displaced upwardly relative to the casing 470 thereby continuing to radially expand and plastically deform the casing until the locking dogs 656 engage and push on the lower end of the casing 470. When the locking dogs 656 engage and push on the lower end of the casing 470, the locking dogs 656, the float valve assembly 654, the differential piston 650, the dart guide sleeve 648, the lower mandrel 646, the bypass valve 644, the elastomeric coating 640, the bypass valve body 638, the expandable sealing sleeve 636, the retaining collet 634, the guide 632, the sealing sleeve expansion cone 630, the expansion cone mandrel 628, the bypass valve operating probe 626, the pressure balance piston 624, the emergency release sleeve 622, the resilient locking ring 620, the locking ring retainer 618, the locking dogs 616, the locking dog retainer sleeve 614, the torsion locking pin 612, the lower mandrel 610, the release housing 608, the lower cone retainer 606, the lower cam 604, and the lower cone segments 602 are displaced downwardly in the longitudinal direction relative to the cone mandrel 588. As a result, the upper cam 598 and the upper cone segments 600 are moved out of axial alignment with the lower cone segments 602 and the lower cam 604 thereby collapsing the

segmented expansion cone. Furthermore, the locking ring 620 is moved from the lock ring groove 588d to the lock ring groove 588e thereby releasably fixing the new position of the lower cone segments 602 and the lower cam 604.

In particular, as illustrated in Fig. 30a, when a downward tensile longitudinal force is initially applied to the lower mandrel 610 relative to cone mandrel 588, the lower mandrel, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 when the applied tensile force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d. As illustrated in Fig. 30b, if the applied tensile force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d, the lower mandrel 610, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 thereby displacing the annular recess 614a of the locking dog retainer sleeve downwardly relative to the locking dogs 616. As a result, the locking dogs 616 are released from engagement with the locking dog grooves 588h of the cone mandrel 588 thereby permitting the lower cone segments 602, the lower cam 604, and the lower cone retainer 606 to be displaced downwardly relative to the cone mandrel 588.

As illustrated in Fig. 30c, further downward displacement of the lower mandrel 610 then causes the torsion locking pin 612 to engage and displace the release housing 608 downwardly relative to the cone mandrel 588 thereby displacing the locking dogs 616, the lower cone retainer 606, the lower cam 604, and the lower cam segments 602 downwardly relative to the cone mandrel. As a result, the lower cone segments 602 and the lower cam 604 are displaced downwardly out of axial alignment with the upper cam 598 and the upper cam segments 600 thereby collapsing the segmented expansion cone. Furthermore, the downward displacement of the locking dog retainer sleeve 614 also displaced the locking ring retainer 618 and the locking ring 620 downwardly relative to the cone mandrel 588 thereby relocating the locking ring from the lock ring groove 588d to the lock ring groove 588e. In this manner, the now position of the lower cone segments 602 and the lower cam 604 are thereby releasably fixed relative to the cam mandrel 588 by the locking ring 620.

The operations of Figs. 30a-30c may be reversed, and the segmented expansion cone may again be expanded, by applying a upward compressive force to the lower mandrel 610. If the compressive force is sufficient, the locking ring 620 will be released from engagement with the lock ring groove 588e, thereby permitting the lower mandrel 610 and the locking dog retainer 614 to be displaced upwardly relative to the cone mandrel 588. As a result, the locking dog retainer 614 will engage and displace the locking dogs 616, the lower cam 604, the lower cone segments 602, the lower cone retainer 606, and the release housing 608 upwardly relative to the cone mandrel 588 thereby bringing the upper cam 598 and the upper cone segments 600 back into axial alignment with the lower cone segments 602 and the lower cam 604. As a result, the segmented expansion cone is once again expanded. Once the segmented cone has been fully expanded, the locking dogs 616 will once again be positioned in alignment with the locking dog grooves 588h of the cone mandrel 588 and will thereby once again engage the locking dog grooves. The continued upward displacement of the lower mandrel 610 relative to cone mandrel 588 will thereby also upwardly displace the locking dog retainer 614 upwardly relative to the cone mandrel thereby once again capturing and restraining the locking dogs 616 within the annular recess 614a of the locking dog retainer. As a result, the new expansion position of the lower cone segments 602 and the lower cam 604 relative to the cone mandrel 588 will be releasably locked by the locking dogs 616. Furthermore, the locking ring 620 will also be relocated from engagement with the lock ring groove 588e to engagement with the lock ring groove 588d to thereby releasably lock the expanded segmented cone in the expanded position.

Referring to Figs. 31a-31n, the continued injection of the fluidic material 702 into the apparatus 400 continues to pressurize the piston chambers 706, 708, and 710 thereby further displacing the pistons upwardly 526, 530, and 536 upwardly relative to the support member 402. Because the engagement of the locking dogs 656 with the lower end of the casing 470 prevents float valve 654 from entering the casing, the continued upward displacement of the pistons 526, 530, and 536 relative to the support member 402 causes the bypass valve operating probe 626 to be displaced upwardly relative to the support member thereby disengaging the bypass valve operating probe from the probe guide 642, and also causes the sealing sleeve expansion cone 630 to be displaced upwardly relative to the expandable sealing sleeve 636 thereby radially

expanding and plastically deforming the sealing sleeve 636 and the elastomeric coating 640 into sealing engagement with the interior surface of the lower end of the casing 470. As a result, the lower end of the casing 470 is fluidicly sealed by the combination of the sealing engagement of the sealing sleeve 636 and elastomeric coating 640 with the interior surface of the lower end of the casing and the positioning the dart 704 within the passage 646a of the lower mandrel 646.

Continued injection of the fluidic material 702 into the apparatus 400 continues to pressurize the piston chambers 706, 708, and 710 until the pistons 536, 530 and 536 are displaced upwardly relative to the casing 470 to their maximum upward position relative to the support member 402. As a result, the dart ball guide 524 impacts the positive casing lock mandrel 478 with sufficient force to shear the shear pins, 428a and 428b, thereby decoupling the positive casing lock mandrel 478 from the casing lock barrel adaptor 474. The positive casing lock mandrel 478 is then displaced upwardly relative to the support member 402 which in turn displaces the positive casing lock releasing mandrel 476 upwardly relative to the positive casing locking dogs 464. As a result, the internal flanges, 464a and 464b, of the positive casing locking dogs are relocated into engagement with the annular recesses, 476c and 476d, respectively, of the positive casing lock releasing mandrel 476. The positive casing lock casing collar 466 is thereby released from engagement with the positive casing locking dogs 464 thereby releasing the casings 468 and 470 from engagement with the support member 402. As a result, the positions of the casings, 468 and 470, are no longer fixed relative to the support member 402.

Referring to Figs. 32a-32k, the injection of the fluidic material 702 is stopped and the support member 402 is then lowered into the wellbore 700 until the float valve assembly 654 impacts the bottom of the wellbore. The support member 402 is then further lowered into the wellbore 700, with the float valve assembly 654 resting on the bottom of the wellbore, until the bypass valve operating probe 626 impacts and displaces the bypass valve 644 downwardly relative to the bypass valve body 638 to fluidicly couple the passages, 638a and 644b, and the passages, 638b and 644c, and until sufficient upward compressive force has been applied to the lower mandrel 610 to re-expand the segmented expansion cone provided by the cone segments, 600 and

602. In an exemplary embodiment, the collet locking member 644d of the bypass valve 644 will also engage an end of the bypass valve operating probe 626.

In an exemplary embodiment, the support member 402 is lowered downwardly into the wellbore 700 such that sufficient upward compressive force is applied to the lower mandrel 610 to release the locking ring 620 from engagement with the lock ring groove 588e, thereby permitting the lower mandrel 610 and the locking dog retainer 614 to be displaced upwardly relative to the cone mandrel 588. As a result, the locking dog retainer 614 will engage and displace the locking dogs 616, the lower cam 604, the lower cone segments 602, the lower cone retainer 606, and the release housing 608 upwardly relative to the cone mandrel 588 thereby bringing the upper cam 598 and the upper cone segments 600 back into axial alignment with the lower cone segments 602 and the lower cam 604. As a result, the segmented expansion cone is once again expanded. Once the segmented cone has been fully expanded, the locking dogs 616 will once again be positioned in alignment with the locking dog grooves 588h of the cone mandrel 588 and will thereby once again engage the locking dog grooves. The continued upward displacement of the lower mandrel 610 relative to cone mandrel 588 will thereby also upwardly displace the locking dog retainer 614 upwardly relative to the cone mandrel thereby once again capturing and restraining the locking dogs 616 within the annular recess 614a of the locking dog retainer. As a result, the new expansion position of the lower cone segments 602 and the lower cam 604 relative to the cone mandrel 588 will be releasably locked by the locking dogs 616. Furthermore, the locking ring 620 will also be relocated from engagement with the lock ring groove 588e to engagement with the lock ring groove 588d to thereby releasably lock the expanded segmented cone in the expanded position.

A hardenable fluidic sealing material 712 may then be injected into the apparatus 400 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 522a, 526a, 529a, 530a, 534a, 536a, 544a, 554a, 566a, 588a, 622a, 610a, 626a, 638a, 638b, 644b, and 644c, and out of the apparatus through the circumferential gaps defined between the circumferentially spaced apart locking dogs 656 into the annulus between the casings 468 and 470 and the wellbore 700. In an exemplary embodiment, the hardenable fluidic sealing material 712 is a cement suitable for well construction. The

hardenable fluidic sealing material 712 may then be allowed to cure before or after the further radial expansion and plastic deformation of the casings 468 and/or 470.

Referring to Figs. 33a-33p, after completing the injection of the fluidic material 712, the support member 402 is then lifted upwardly thereby displacing the bypass valve operating probe 626 and the bypass valve 644 upwardly to fluidicly decouple the passages, 638a and 644b and 638b and 644c, until the collet locking member 644d of the bypass valve is decoupled from the bypass valve operating probe. The support member 402 is then further lifted upwardly until the segmented expansion cone, provided by the interleaved and axially aligned cone segments, 600 and 602, impacts the transition between the expanded and unexpanded sections of the casing 470. A fluidic material 714 is then injected into the apparatus 400 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 478a, 484a, 524a, 522a, 526a, 529a, 530a, 534a, 536a, 544a, 554a, 566a, 588a, 622c, 610a, and 626a thereby pressurizing the interior portion of the casing 470 below the packer cups, 572 and 582. In particular, the packer cups, 572 and 582, engage the interior surface of the casings 468 and/or 470 and thereby provide a dynamic movable fluidic seal. As a result, the pressure differential across the packer cups, 572 and 582, causes an upward tensile force that pulls the segmented expansion cone provided by the axially aligned and interleaved cone segments, 600 and 602, to be pulled upwardly out of the casings 468 and/or 407 by the packer cups thereby radially expanding and plastically deforming the casings. Furthermore, the lack of a fluid tight seal between the cone segments, 572 and 582, and the casings 468 and/or 470 permits the fluidic material 714 to lubricate the interface between the cone segments and the casings during the radial expansion and plastic deformations of the casings by the cone segments. In an exemplary embodiment, during the radial expansion and plastic deformation of the wellbore casings 468 and/or 470, the support member 402 is lifted upwardly out of the wellbore 700. In several alternative embodiments, the casings 468 and/or 470 are radially expanded and plastically deformed into engagement with at least a portion of the interior surface of the wellbore 700.

Referring to Figs. 34a-34l, in an exemplary embodiment, a preexisting wellbore casing 716 is coupled to, or otherwise support by or within, the wellbore 700. In an exemplary embodiment, during the radial expansion and plastic deformation of the portion of the

casing 468 and/or 470 that overlaps with the preexisting casing 716, during the continued injection of the fluidic material 714, the bypass valve body 412 is shifted downwardly relative to the gripper upper mandrel 406 thereby fluidicly coupling the casing gripper hydraulic ports, 406f and 406h. As a result, the interior passages, 428a and 440a, of the gripper bodies, 428 and 440, are pressurized thereby displacing the hydraulic slip pistons, 432a-432j and 442a-442j, radially outward into engagement with the interior surface of the preexisting wellbore casing 716. After the hydraulic slip pistons, 432a-432j and 442a-442j, engage the preexisting wellbore casing 716, the continued injection of the fluidic material 714 causes the segmented expansion cone including the axially aligned and interleaved cone segments, 600 and 602, to be pulled through the overlapping portions of the casings 468 and/or 470 and the preexisting wellbore casing by the upward displacement of the pistons, 526, 530, and 536, relative to the preexisting wellbore casing. In this manner, the overlapping portions of the casings 468 and/or 470 and the preexisting wellbore casing 716 are simultaneously radially expanded and plastically deformed by the upward displacement of the segmented expansion cone including the axially aligned and interleaved cone segments, 600 and 602. In several alternative embodiments, the hydraulic slip pistons, 432a-432j and 442a-442j, are displaced radially outward into engagement with the interior surface of the casings 468 and/or 470 and/or the preexisting wellbore casing 716.

In an exemplary embodiment, the bypass valve body 412 is shifted downwardly relative to the gripper upper mandrel 406 by lowering the casing gripper locking dogs, 424a and 424b, using the support member 402 to a position below the unexpanded portions of the casings 468 and/or 470 into the radially expanded and plastically deformed portions of the casings. The ends of the casing gripper locking dogs, 424a and 424b, may then pivot outwardly out of engagement with the outer annular recess 406d of the gripper upper mandrel 406 and then are displaced downwardly relative to the gripper upper mandrel, along with the bypass valve body 412, due to the downward longitudinal force provided by the compressed spring 418. As a result, the bypass valve body 412 is placed in the neutral position illustrated in Fig. 25h. The casing gripper locking dogs, 424a and 424b, are then displaced upwardly relative to the casing gripper upper mandrel 406 using the support member 402 thereby impacting the casing gripper locking dogs with the interior diameter of the unexpanded portion of the casings

468 and/or 470. As a result, the casing gripper locking dogs, 424a and 424b, are displaced downwardly, along with the bypass valve body 412. relative to the casing gripper upper mandrel 406 until the ends of the casing gripper locking dogs pivot radially inwardly into engagement with the outer annular recess 406e of the casing gripper upper mandrel thereby positioning the bypass valve body in an active position, as illustrated in Fig. 34a, in which the casing gripper hydraulic ports, 406f and 406h, are fluidicly coupled.

In an alternative embodiment, the bypass valve body 412 is shifted downwardly relative to the gripper upper mandrel 406 by raising the casing gripper locking dogs, 424a and 424b, to a position above the casing 468 using the support member 402 thereby permitting the ends of the casing gripper locking dogs to pivot radially outward out of engagement with the outer annular recess 406d of the gripper upper mandrel 406. The ends of the casing gripper locking dogs, 424a and 424b, are then displaced downwardly relative to the gripper upper mandrel, along with the bypass valve body 412, due to the downward longitudinal force provided by the compressed spring 418, into engagement with the outer annular recess 406e of the casing gripper upper mandrel thereby positioning the bypass valve body in an active position, as illustrated in Fig. 34a, in which the casing gripper hydraulic ports, 406f and 406h, are fluidicly coupled.

In an exemplary embodiment, the process of pulling the segmented expansion cone provided by pulling the interleaved and axially aligned cone segments, 600 and 602, upwardly through the overlapping portions of the casings 468 and/or 470 and the preexisting wellbore casing 716 is repeated by repeatedly stroking the pistons, 526, 530, and 536, upwardly by repeatedly a) injecting the fluidic material 714 to pressurize the apparatus 400 thereby displacing the segmented expansion cone upwardly, b) depressurizing the apparatus by halting the injection of the fluidic material, and then c) lifting the elements of the apparatus upwardly using the support member 402 in order to properly position the pistons for another upward stroke.

Referring to Figs. 35a-35l, in an exemplary embodiment, during the operation of the apparatus 400, the segmented expansion cone provided by the interleaved and axially aligned cone segments, 600 and 602, may be collapsed thereby moving the cone

segments out of axial alignment by injecting a ball plug 718 into the apparatus using the injected fluidic material 714 through the passages 402a, 404a, 406a, 454a, 450a, 456a, 458a, 476a, 484a, 522a, 529a, 534a, 544a, 554a, 566a, and 588a into sealing engagement with the end of the emergency releasing sleeve 622. The continued injection of the fluidic material 714 following the sealing engagement of the ball plug 718 with the end of the emergency releasing sleeve 622 will apply a downward longitudinal tensile force to the lower mandrel 610. As a result, as illustrated and described above with reference to Fig. 30a, when the downward tensile longitudinal force is initially applied to the lower mandrel 610 relative to cone mandrel 588, the lower mandrel, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 when the applied tensile force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d. As illustrated in Fig. 30b, if the applied downward tensile longitudinal force is sufficient to release the locking ring 620 from engagement with the lock ring groove 588d, the lower mandrel 610, the locking dog retainer sleeve 614, and the locking ring retainer 618 are displaced downwardly relative to the cone mandrel 588 thereby displacing the annular recess 614a of the locking dog retainer sleeve downwardly relative to the locking dogs 616. As a result, the locking dogs 616 are released from engagement with the locking dog grooves 588h of the cone mandrel 588 thereby permitting the lower cone segments 602, the lower cam 604, and the lower cone retainer 606 to be displaced downwardly relative to the cone mandrel 588.

As illustrated in Fig. 30c, further downward displacement of the lower mandrel 610 then causes the torsion locking pin 612 to engage and displace the release housing 608 downwardly relative to the cone mandrel 588 thereby displacing the locking dogs 616, the lower cone retainer 606, the lower cam 604, and the lower cam segments 602 downwardly relative to the cone mandrel. As a result, the lower cone segments 602 and the lower cam 604 are displaced downwardly out of axial alignment with the upper cam 598 and the upper cam segments 600 thereby collapsing the segmented expansion cone. Furthermore, the downward displacement of the locking dog retainer sleeve 614 also displaced the locking ring retainer 618 and the locking ring 620 downwardly relative to the cone mandrel 588 thereby relocating the locking ring from the lock ring groove 588d to the lock ring groove 588e. In this manner, the now

position of the lower cone segments 602 and the lower cam 604 are thereby releasably fixed relative to the cam mandrel 588 by the locking ring 620.

Referring now to Fig. 36a, an exemplary embodiment of the operation of the pressure balance piston 624 during an exemplary embodiment of the operation of the apparatus 400 will now be described. In particular, after the dart 704 is positioned and seated in the passage 646a of the lower mandrel 646, the operating pressure within the passage 622c will increase. As a result, the operating pressure within the passages 622a will increase thereby increasing the operating pressures within the passages, 588f and 588g, of the cone mandrel 588, and within an annulus 720 defined between the cone mandrel 588 and lower mandrel 610. The operating pressure within the annulus 720 acts upon an end face of the pressure balance piston 624 thereby applying a downward longitudinal force to the cone mandrel 588. As a result, the cone mandrel 588 and the locking dog retainer sleeve 614 could inadvertently be displaced away from each other in opposite directions during the pressurization of the interior passages of the apparatus 400 caused by the placement of the dart 704 in the passage 646a of the lower mandrel 646 thereby potentially collapsing the segmented expansion cone including the interleaved and axially aligned cone segments, 600 and 602. Thus, the pressure balance piston 624, in an exemplary embodiment, neutralizes the potential effects of the pressurization of the interior passages of the apparatus 400 caused by the placement of the dart 704 in the passage 646a of the lower mandrel 646.

Referring now to Fig. 36b, an exemplary embodiment of the operation of the pressure balance piston 624 during another exemplary embodiment of the operation of the apparatus 400 will now be described. In particular, during the placement of the ball 718 within the passage 622c of the releasing sleeve 622, the interior passages of the apparatus 400 upstream from the ball are pressurized. However, since the ball 718 blocks the passage 622c, the passage 622a is not pressurized. As a result, the pressure balance piston 624 does not apply a downward longitudinal force to the cone mandrel 588. As a result, the pressure balance piston 624 does not interfere with the collapse of the segmented expansion cone including the interleaved and axially aligned cone segments, 600 and 602, caused by the placement of the ball 718 within the mouth of the passage 622c of the release sleeve 622.

It is understood that variations may be made in the foregoing without departing from the scope of the invention. For example, the teachings of the present illustrative embodiments may be used to provide a mono diameter wellbore casing, pipeline, or structural support. Furthermore, the elements and teachings of the various illustrative embodiments may be combined in whole or in part in some or all of the illustrative embodiments. In addition, the expansion surfaces of the upper and lower cone segments, 600 and 602, may include any form of inclined surface or combination of inclined surfaces such as, for example, conical, spherical, elliptical, and/or parabolic that may or may not be faceted. Finally, one or more of the steps of the methods of operation of the exemplary embodiments may be omitted and/or performed in another order within the scope of the claims.

Although illustrative embodiments of the invention have been shown and described, a wide range of modification, changes and substitution is contemplated in the foregoing disclosure within the scope of the claims. Accordingly, it is appropriate that the appended claims be construed broadly.

Claims

1. A method for forming a mono diameter wellbore casing within a borehole that includes a preexisting wellbore casing, comprising:

supporting the expandable tubular member, an hydraulic actuator, and an adjustable expansion device within the borehole;

increasing the size of the adjustable expansion device;

displacing the adjustable expansion device upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform a portion of the expandable tubular member; and

displacing the adjustable expansion device upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member and a portion of the preexisting wellbore casing that overlaps with an end of the remaining portion of the expandable tubular member.

2. The method of claim 1, further comprising:

reducing the size of the adjustable expansion device after the portion of the expandable tubular member has been radially expanded and plastically deformed.

3. The method of claim 2, further comprising:

fluidicly sealing the radially expanded and plastically deformed end of the expandable tubular member after reducing the size of the adjustable expansion device.

4. The method of claim 1, further comprising:

injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the borehole.

5. The method of claim 1, further comprising:

displacing the adjustable expansion cone upwardly relative to the expandable tubular member to radially expand and plastically deform the remaining portion of the expandable tubular member.

6. The method of claim 5, further comprising:

displacing the adjustable expansion cone upwardly relative to the expandable tubular member using the hydraulic actuator to radially expand and plastically deform the end of the remaining portion of the expandable tubular member that overlaps with the preexisting wellbore casing.

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